

## **TABLE OF CONTENTS**

**1- scale print of MK II sten**

**1- scale print of MP-40**

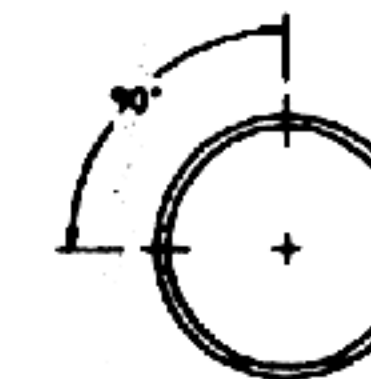
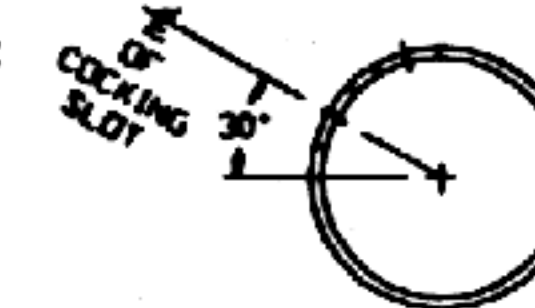
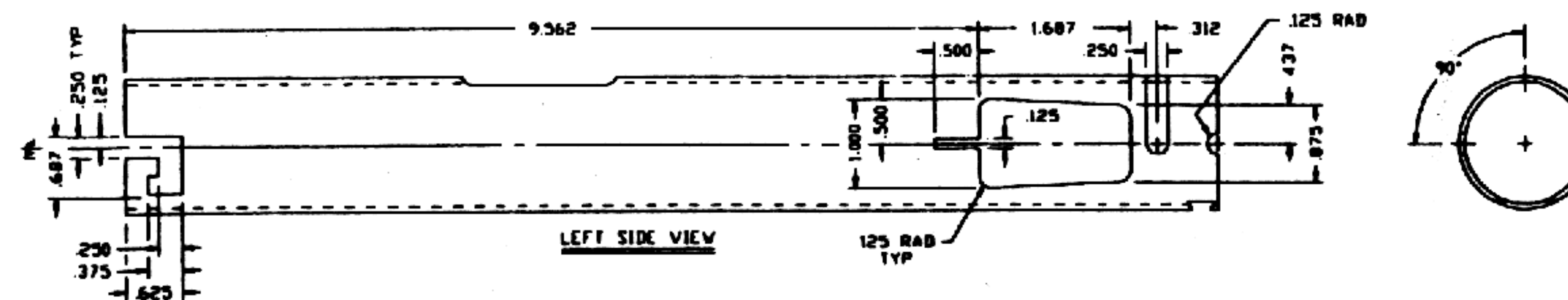
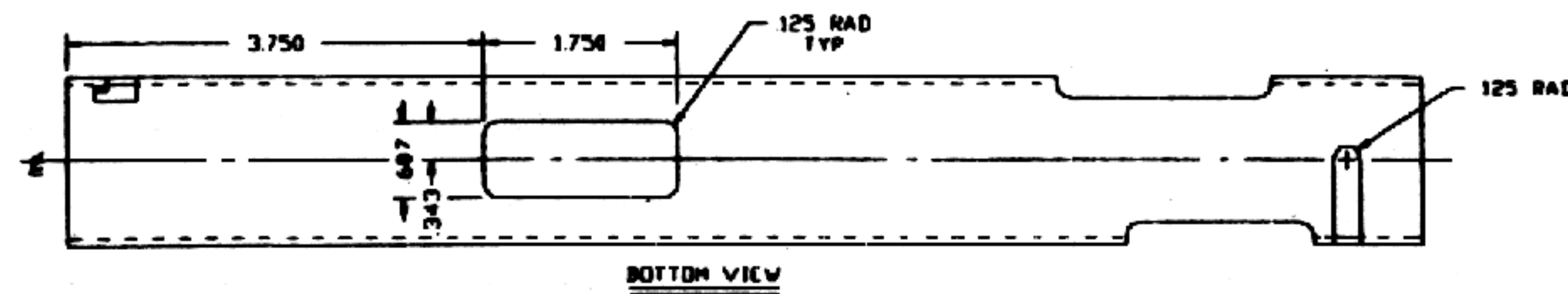
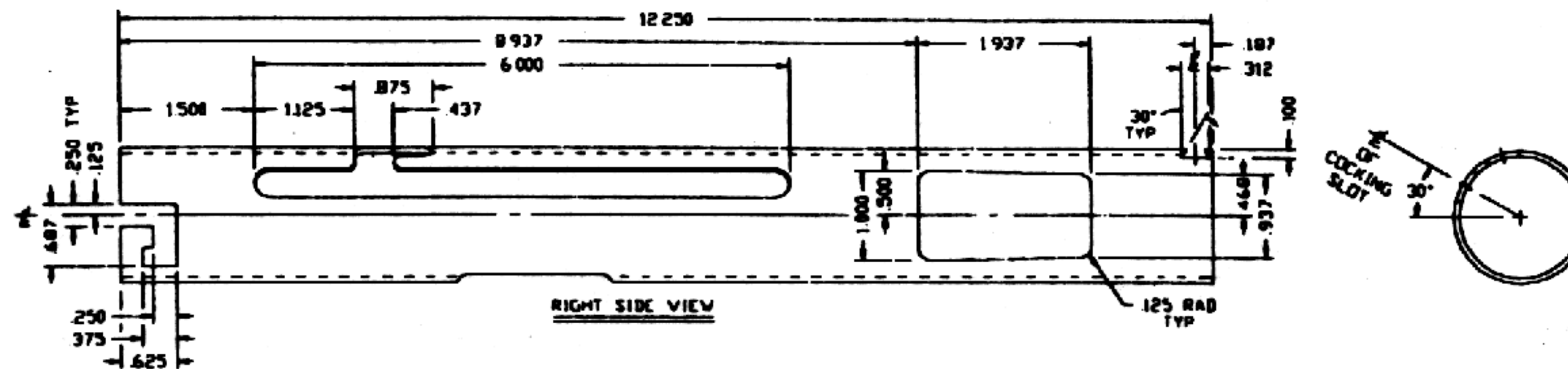
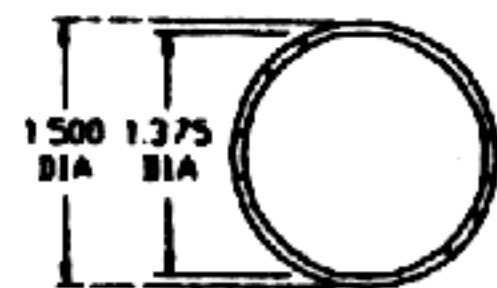
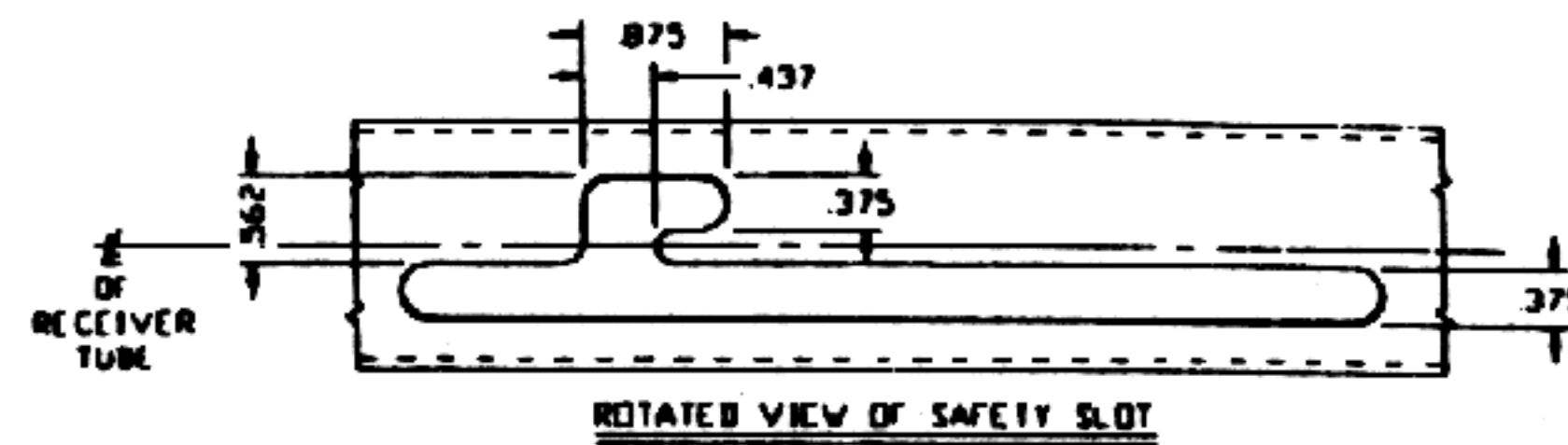
**1- scale print of MK II sten compact**

**1- scale print of Yugoslav 56**

**1- scale print of BMG 50**

**right and left sides**

**PARTS SUPPLIERS ON LAST PAGE**



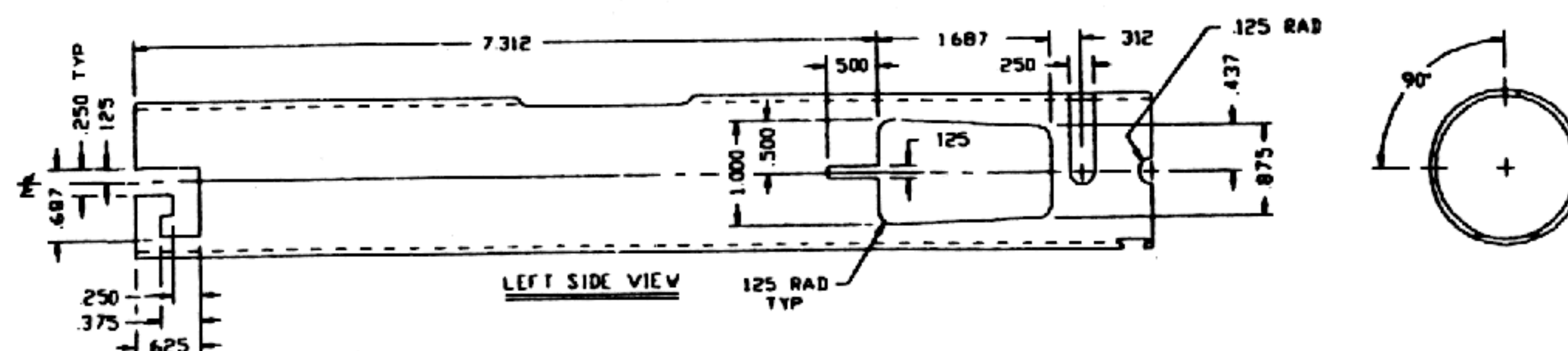
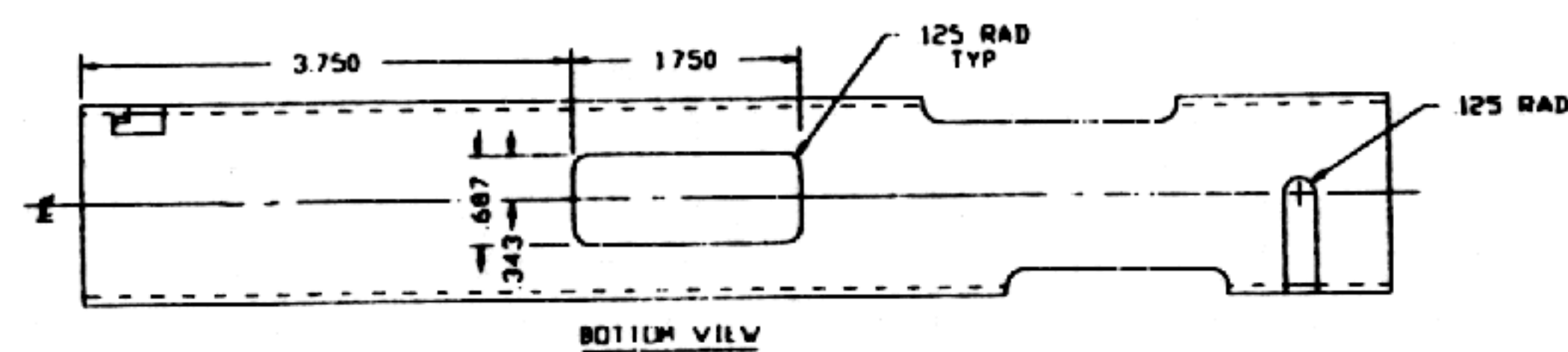
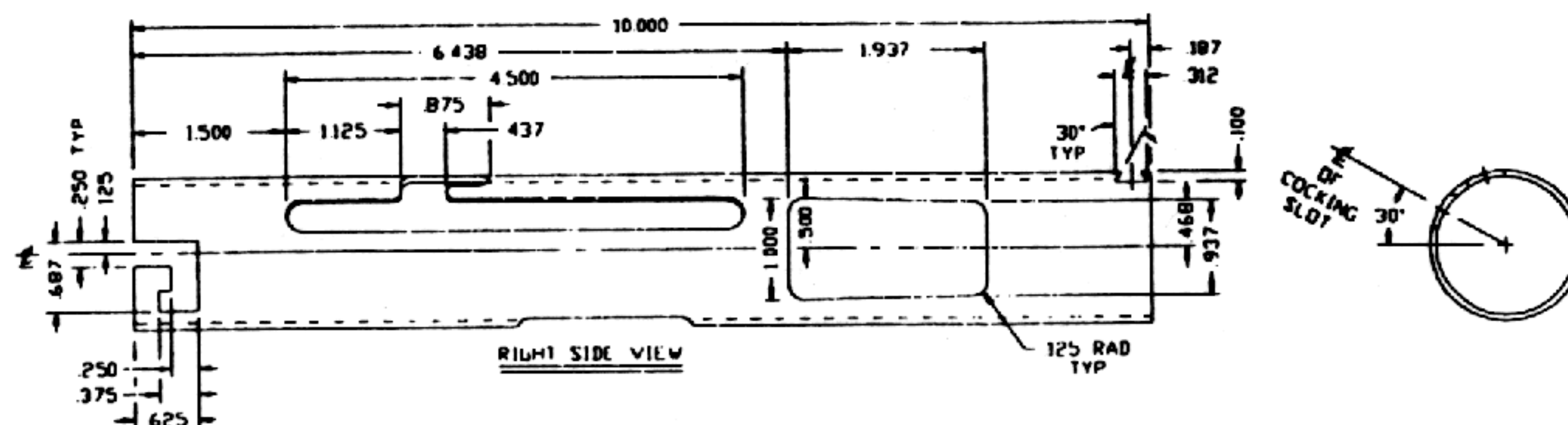
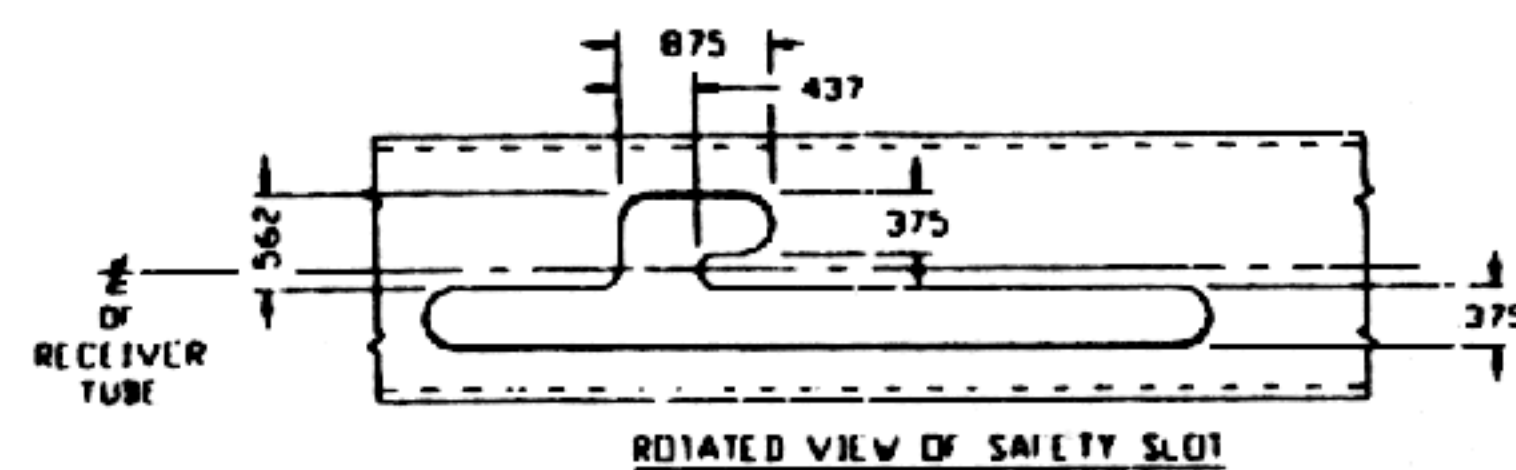
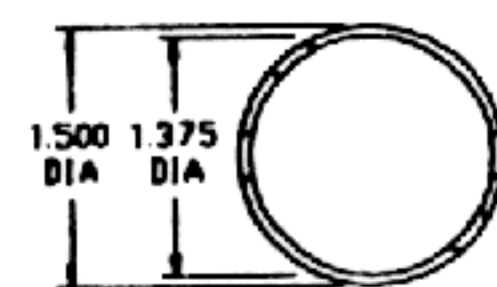
RESTRICTED  
MATERIAL

CONFIDENTIAL

- NOTES:
1. MATERIAL - MILD STEEL SEAMLESS, DRAWN OVER MANDREL 1500 O.D. X 1375 I.D. (.050-.062 WALL)
  2. FINISH - PAINT BLACK

SCALE	FULL	REVISION	SEE NOTE 1	DATE	NO. OF COPIES
DRAWN		FINISH	SEE NOTE 2		REV. 1
TITLE	STEN MK-II RECEIVER (STANDARD MODEL)				NO. 2





RESTRICTED  
MATERIAL

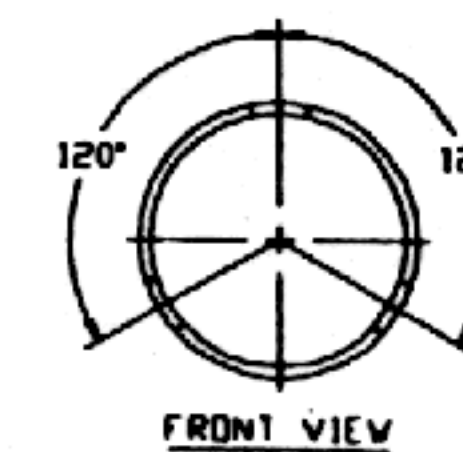
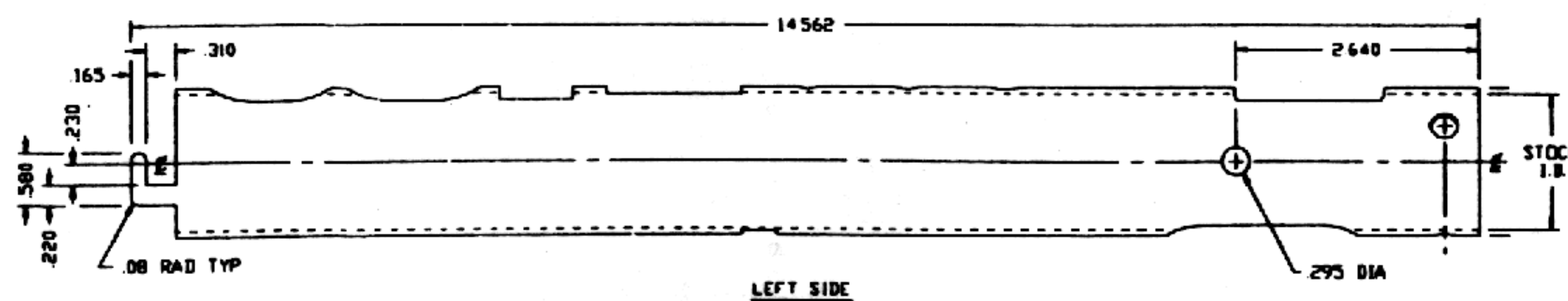
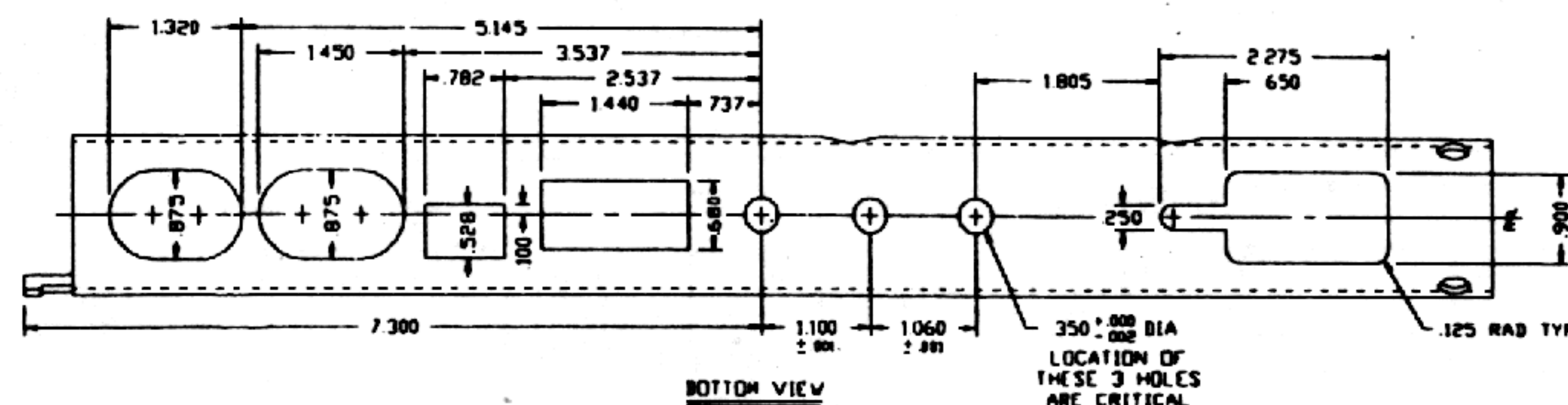
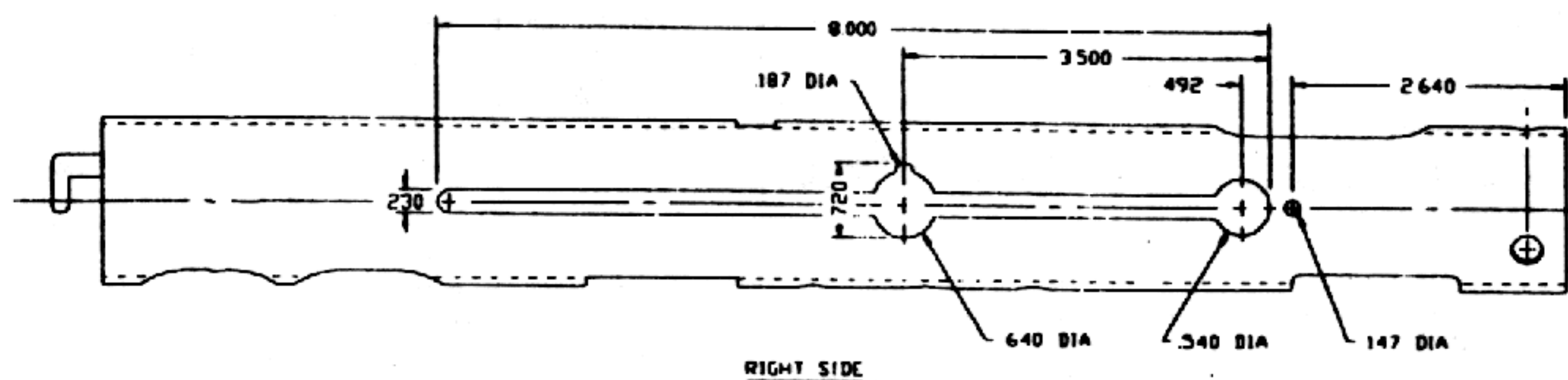
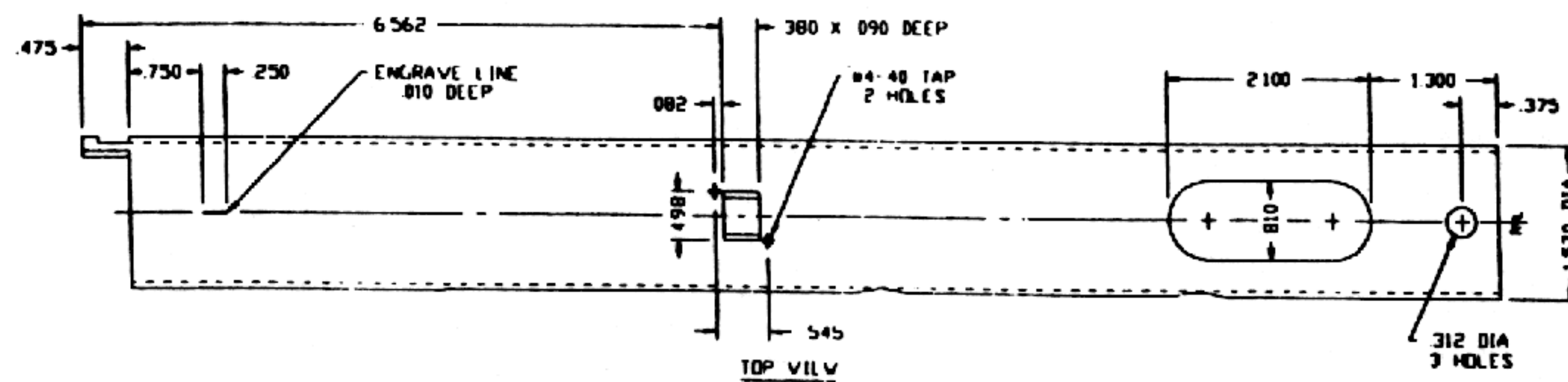
CONFIDENTIAL

NOTES:

1. MATERIAL - MILD STEEL SEAMLESS, DRAWN OVER MANDREL  
1.500 O.D. X 1.375 I.D. (.058-.062 WALL)
2. FINISH - PAINT BLACK

SCALE: FULL	MATERIAL: SEE NOTE 1	DATE	DESIGNED BY: [Signature]
DATE	FINISH: SEE NOTE 2	DATE	DESIGNED BY: [Signature]
TITLE: STEN MK-II RECEIVER (COMPACT MODEL)			REV. [Signature]
			NO.





METHOD OF ATTACHING  
BARREL BUSHING  
DRILL .312 DIA HOLES AT 120°  
POSITIONED .375 FROM FRONT  
AND ELECTRIC WELD  
ALTERNATE FOR NON-GUN  
COLD SOLDER OR SILVER SOLDER

NOTES  
1 MATERIAL- 1.625 O.D. x .093 WALL D.D.M. STEEL TUBE  
2 FINISH- BLUE  
3 CALIBER- 7.62 TOKAREV OR 7.63 MAUSER

RESTRICTED  
MATERIAL

CONFIDENTIAL

SCALE	MATERIAL	DATE	TOLERANCES
FULL	SEE NOTE 1	DATE	DES. ±.001
	SEE NOTE 2	DATE	MAN. ±.002
TITLE		REV.	ANGLE ±.5°
YUGOSLAV 56 RECEIVER			







## **LIST OF PARTS SUPPLIERS**

**wholesale guns and ammo, inc.  
232 blydenburgh rd.  
central islip, NY 11722**

**[www.gunsnammo.com](http://www.gunsnammo.com)**

**international military antiques , inc.  
p.o.box 256 millington ,NJ 07946**

**[www.ima-usa.com](http://www.ima-usa.com)**

**inter ordnance of america l.p.  
3305 westwood industrial drive  
monroe , NC 28110**

**[www.inter-ordnance.com](http://www.inter-ordnance.com)**

**sarco , inc.  
323 union st. p.o. box 98  
stirling , NJ 07980**

**jeffs shooters supply  
p.o.box 1054 trussville , AL 35173**

**rpb industries  
p.o.box 367 avondale est. GA 30002**



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**1- scale print of OWEN MK II 1943**

**1- scale print of REISING**

**1- scale print of SPRINGFIELD M-60 lt. MG**

**PARTS SUPPLIERS ON LAST PAGE**

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**1- scale print of THOMPSON SUB MACHINE GUN M1A1**

**1- scale print of MK 1 and MK 1\* LANCHESTER**

**1- scale print of MODEL 37 right and left side plates**

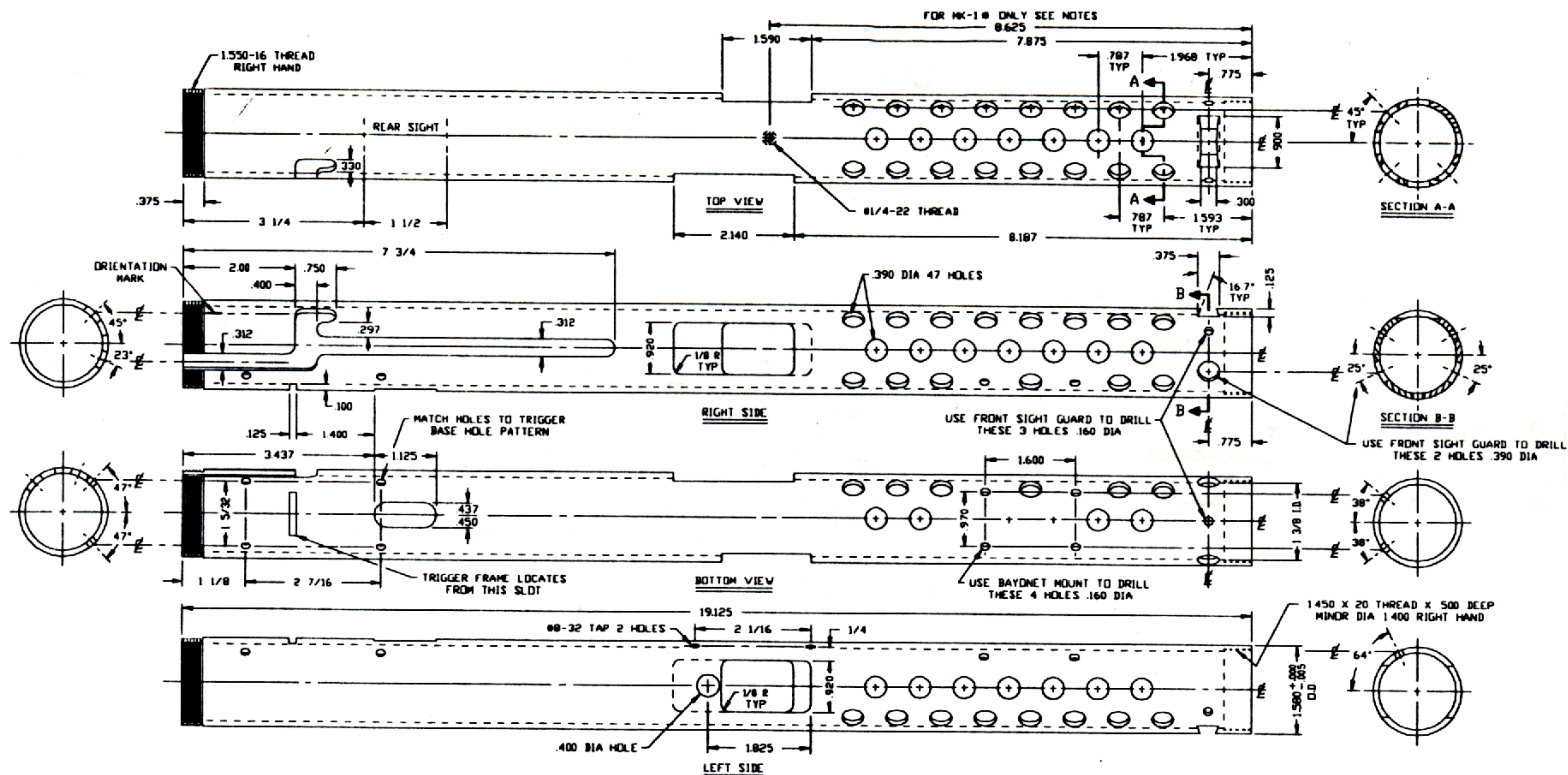
**1- scale print of UD-M42**

**PARTS SUPPLIERS ON LAST PAGE**









#### GENERAL NOTES AND SUGGESTIONS

1. TURN O.D. AND THREAD BOTH ENDS FIRST.
2. MARK 1B IS THE LATER MODEL, FULL AUTO, AND HAS 1/4-22 SCREW IN TOP OF MAGAZINE HOUSING THAT LOCKS BARREL IN PLACE.
3. ALL 160 HOLES WERE ORIGINALLY RIVET HOLES. I DRILL THESE HOLES #29 (.136) AND TAP 88-32 USE 88-32 X 1/4 ROUND HEAD MACHINE SCREWS.
4. WITH END CAP IN PLACE TIGHT, BACKOFF 1/8 TURN AND MAKE A LINE-UP MARK ON BOTH PARTS. PLACE TUBE IN STOCK AND LOCK END CAP IN PLACE. SLIDE MAGAZINE HOUSING ON TUBE AND LOCATE IN STOCK AND INSTALL HINGE SCREW. SPOT DRILL THRU MAGAZINE HOUSING FOR 2 88-32 SCREWS. DRILL #29 AND TAP 88-32 AND INSTALL 2 88-32 SCREWS. THE ORIGINAL ONES FIT. THIS ESTABLISHES THE HOUSING TO THE END CAP. ALL OTHER HOLES ARE RELATIVE TO THE 2 PARTS.
5. LOCATE ALL OTHER HARDWARE BY SPOT DRILLING IN PLACE.
6. MAIN PORTS CAN BE SCRIBED WHILE HOUSING IS IN PLACE. EXTRACTION PORT SIZE IS CORRECT, BUT MAGAZINE HOUSING HOLE IS LARGER.
7. THESE DIMENSIONS WERE COMPILED FROM 3 LANCASTER RECEIVERS.
8. FRONT SIGHT DOVETAIL IS NOT A STANDARD TAPER MACHINE A STRAIGHT SLOT AND TRIM FRONT SIGHT TO FIT AND SOLDER IN PLACE.
9. FINISH BLUE ALL STEEL PARTS. BRASS SHOULD BE NATURAL, NOT PAINTED.
10. BAYONET: ENFIELD P1907 LONG OR P1907/42.
11. MATERIAL: 1 5/8 O.D. X 1 3/8 I.D. DOM 1020 STEEL TUBE.

**CONFIDENTIAL**

**RESTRICTED**

SCALE	FULL	DRAWING	SEE NOTE 11	CRS		TOLERANCES
FINISH		FINISH	SEE NOTE 9	DATE		DEC 2 PL ± .005
TITLE	MK-1 & MK-1B LANCASTER RECEIVER			REV.		DEC 3 PL ± .005
						ANGLES ± .5°
						NO.

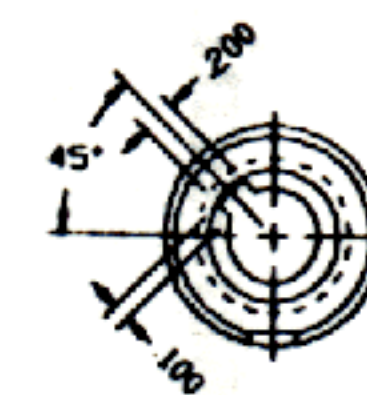
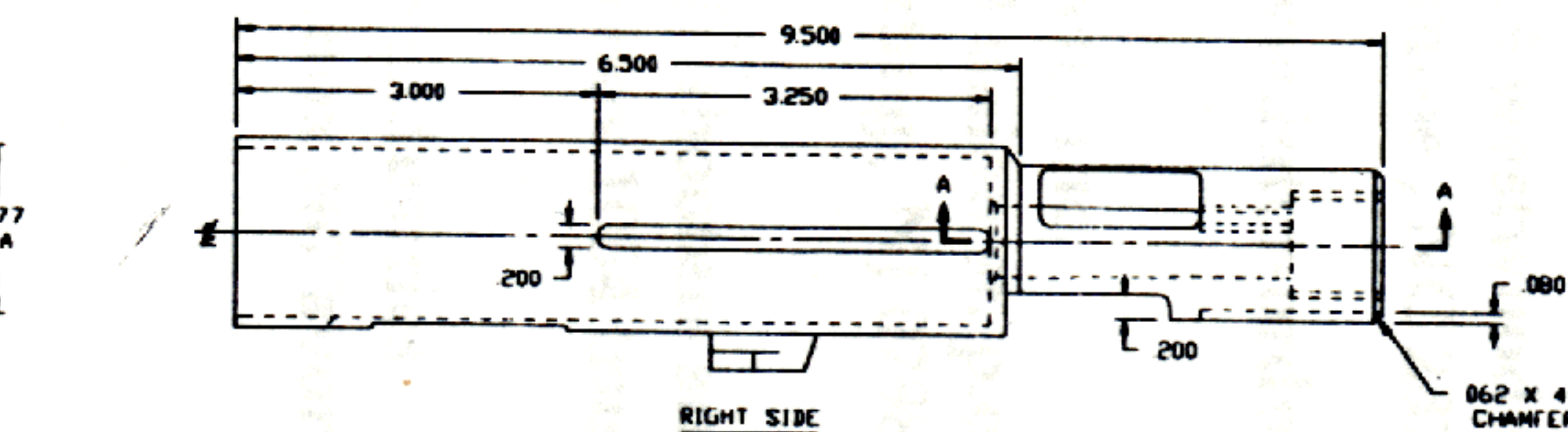
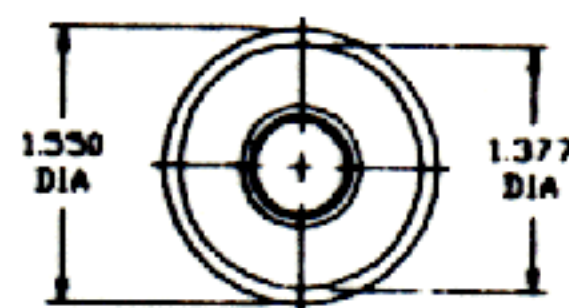




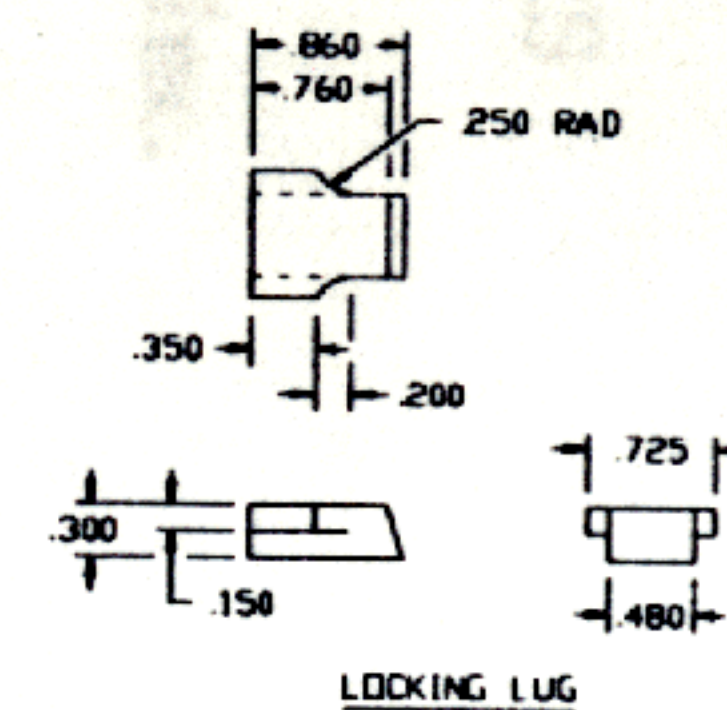
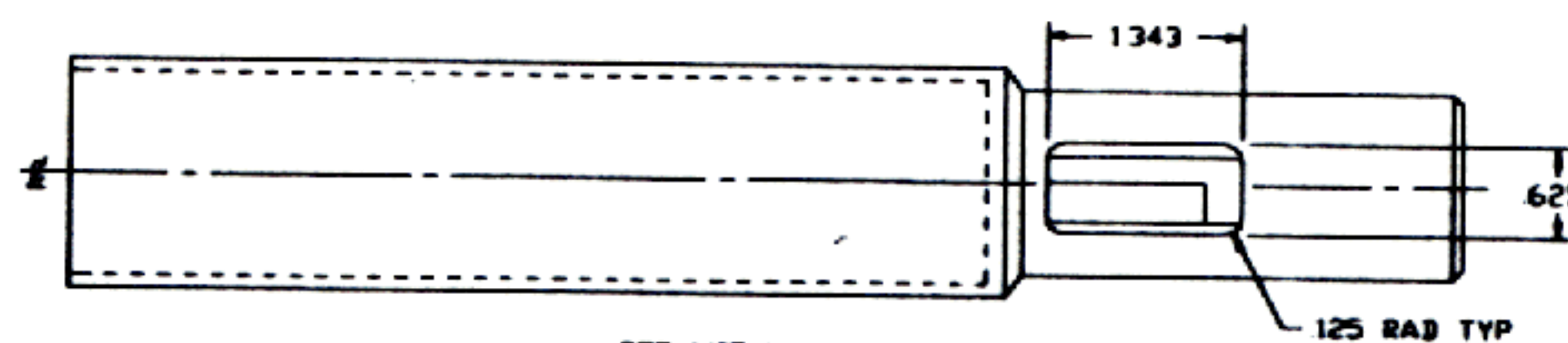
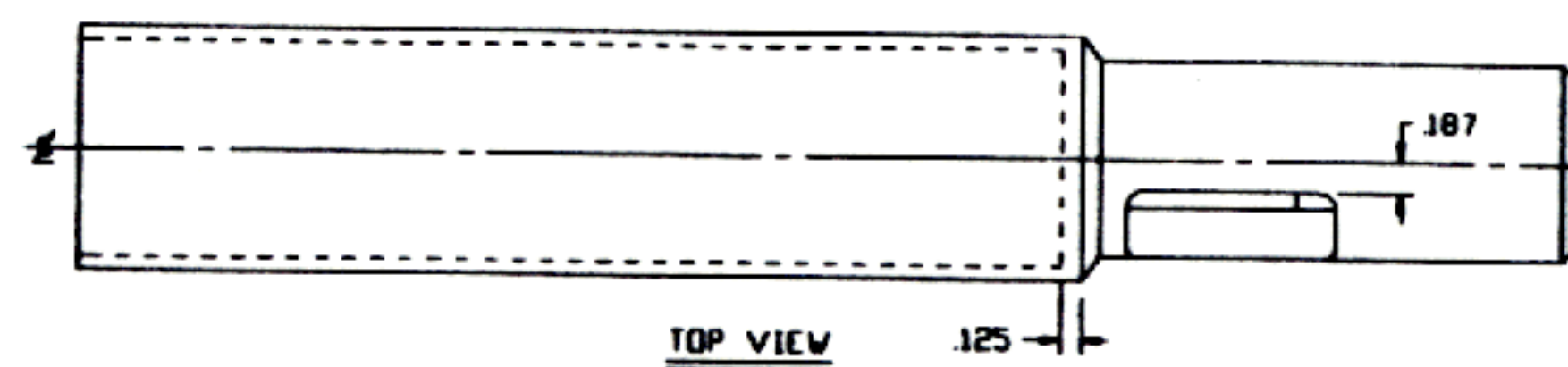
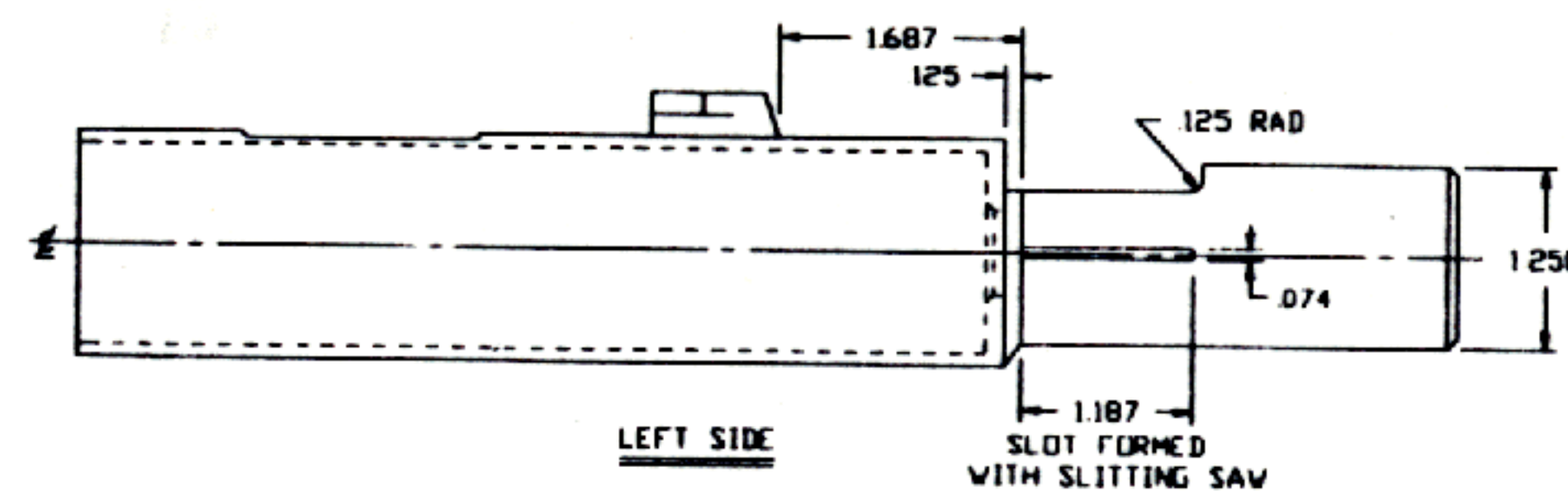
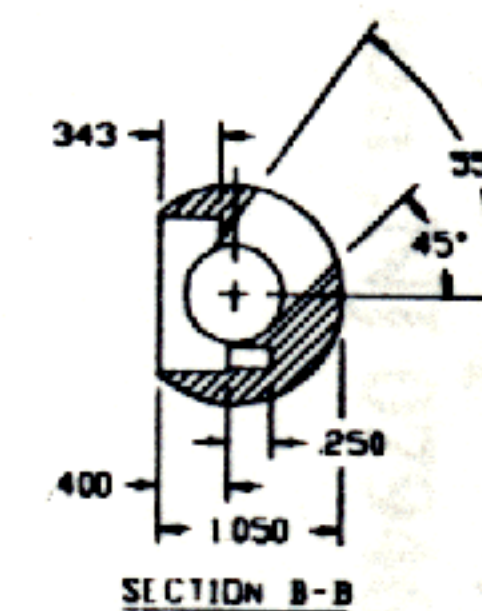
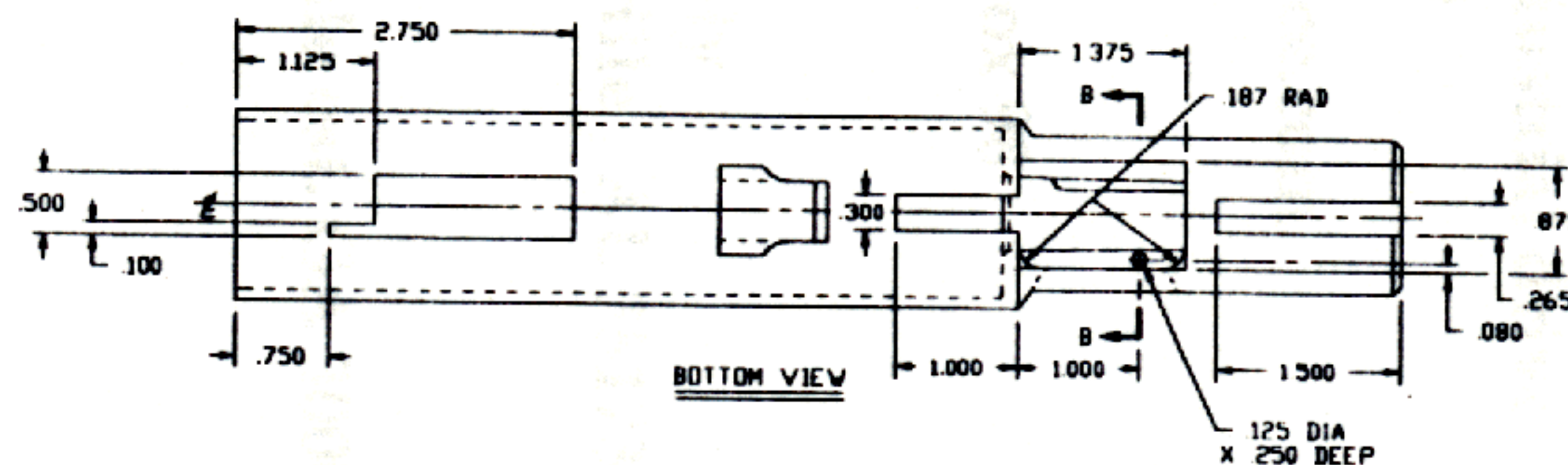








EXTRACTOR SLOT  
RUNS FROM REAR END  
OF THREAD TO FRONT  
OF EXTRACTION PORT



**CONFIDENTIAL**

**NOTES:**

1. MATERIAL - COLD ROLL, HOT ROLL, 4130, 4140 OR 4340 STEEL
2. FINISH - BLUE
3. HEAT TREATMENT - 4130, 4140, 4340 28-32 R/C

**RESTRICTED  
MATERIAL**

SCALE	FULL	MATERIAL	SEE NOTE 1	CR	TOLERANCES
DATE		FINISH	SEE NOTE 2	DATE	DEC 2 PL ± .001
TITLE	UD-M42	RECEIVER	REV.		DEC 2 PL ± .001
					ANGLES ± .5°



## **LIST OF PARTS SUPPLIERS**

**wholesale guns and ammo, inc.  
232 blydenburgh rd.  
central islip, NY 11722**

**[www.gunsnammo.com](http://www.gunsnammo.com)**

**international military antiques , inc.  
p.o.box 256 millington ,NJ 07946**

**[www.ima-usa.com](http://www.ima-usa.com)**

**inter ordnance of america l.p.  
3305 westwood industrial drive  
monroe , NC 28110**

**[www.inter-ordnance.com](http://www.inter-ordnance.com)**

**sarco , inc.  
323 union st. p.o. box 98  
stirling , NJ 07980**

**jeffs shooters supply  
p.o.box 1054 trussville , AL 35173**

**rpb industries  
p.o.box 367 avondale est. GA 30002**



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**1- scale print of THOMPSON 1928-A1 upper**

**1- scale print of THOMPSON 1928 trigger frame**

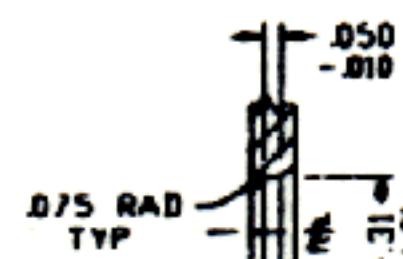
**1- scale print of MP-38**

**1- scale print of BROWNING BAR AUTOMATIC**

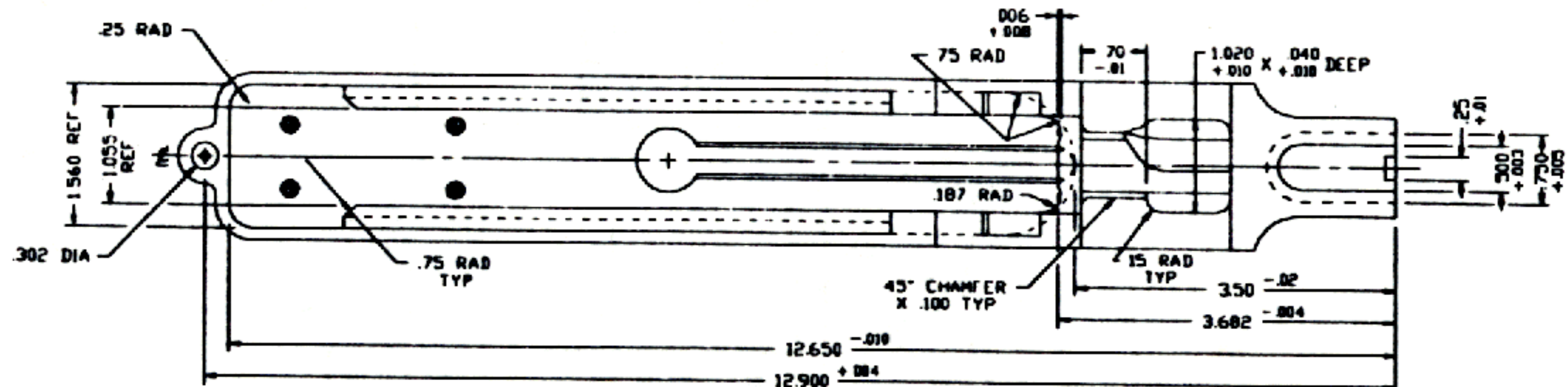
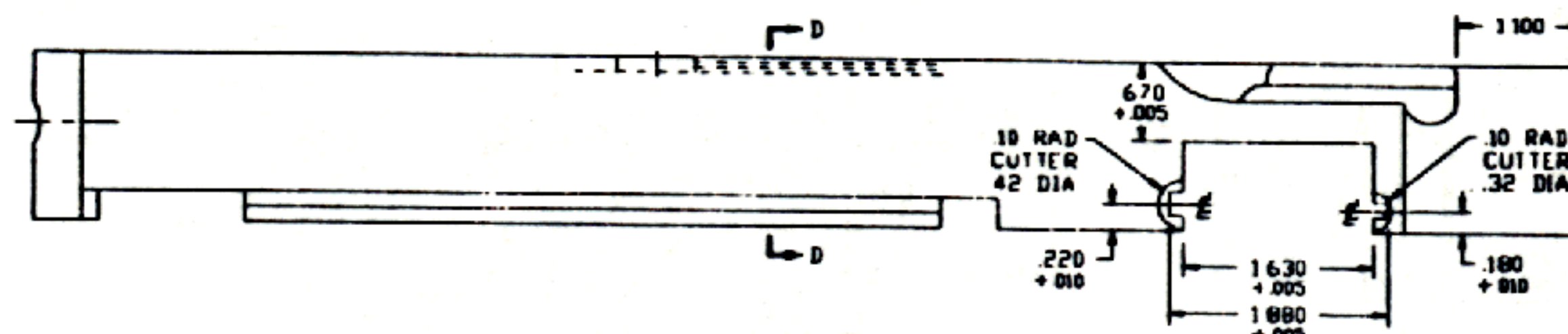
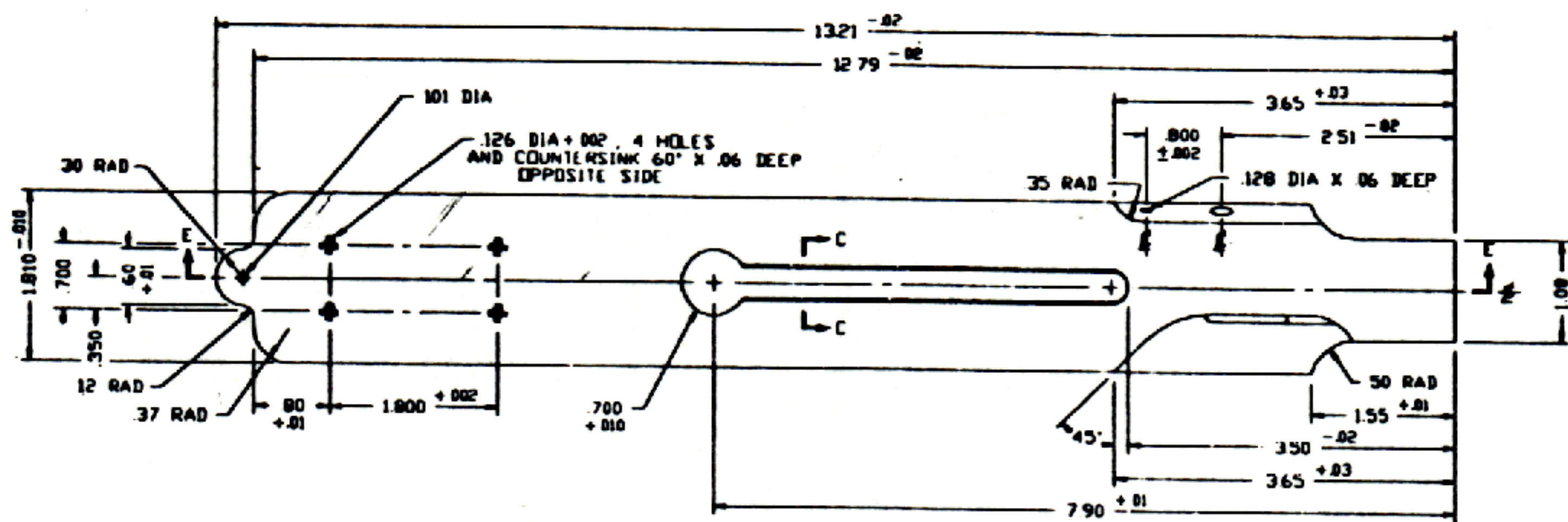
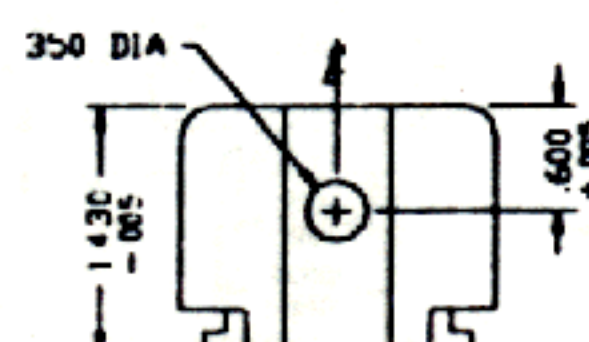
**1- scale print of VICKERS right side plate**

**PARTS SUPPLIERS ON LAST PAGE**

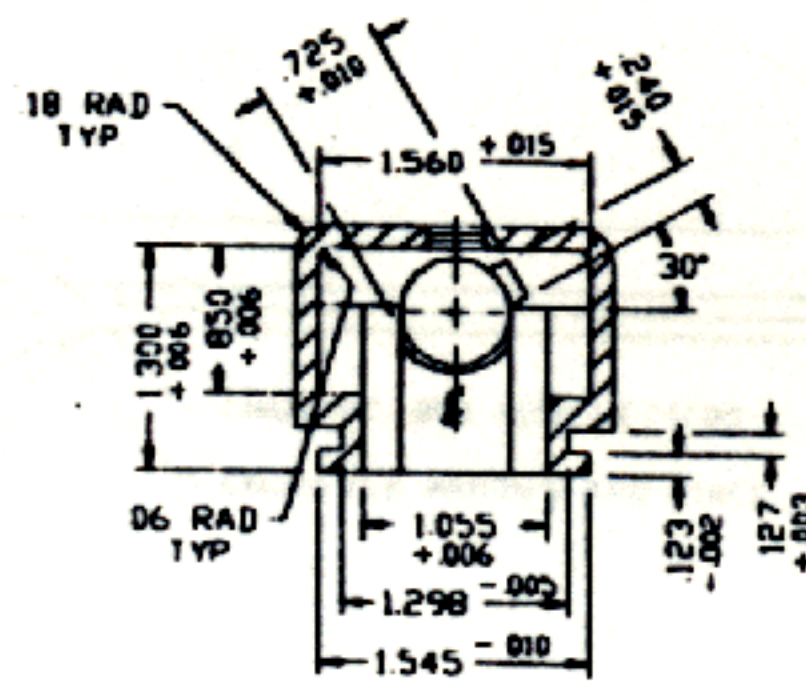
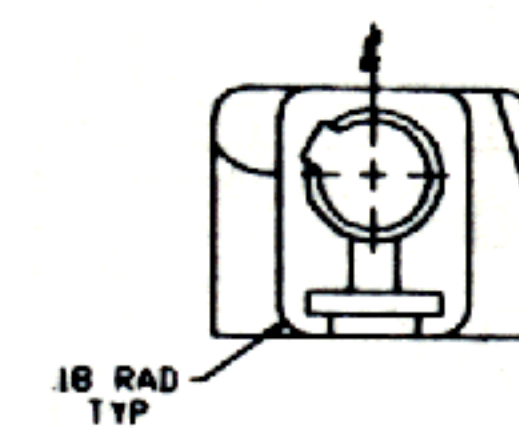




SECTION C-C

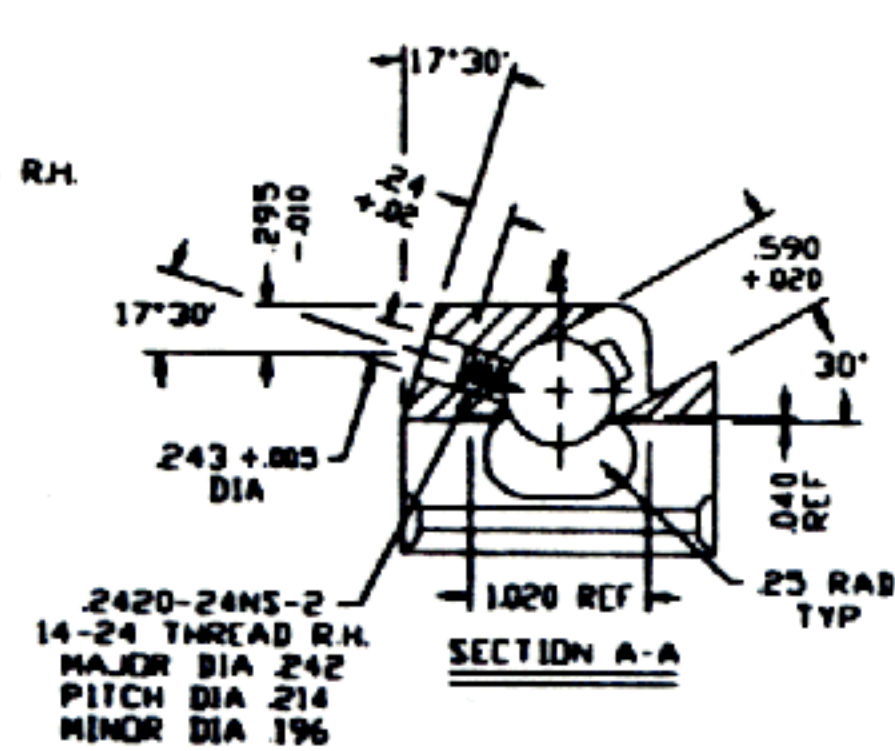


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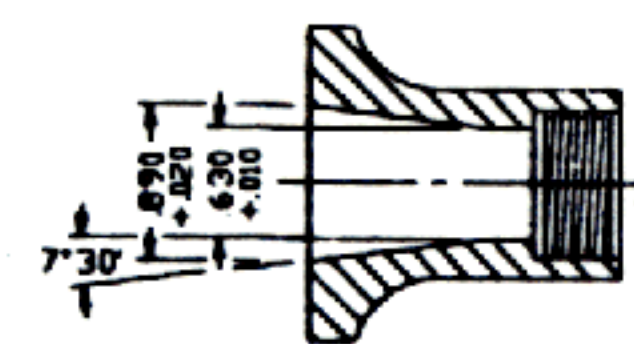


SECTION D-D

**CONFIDENTIAL**



SECTION A-A



SECTION B-B

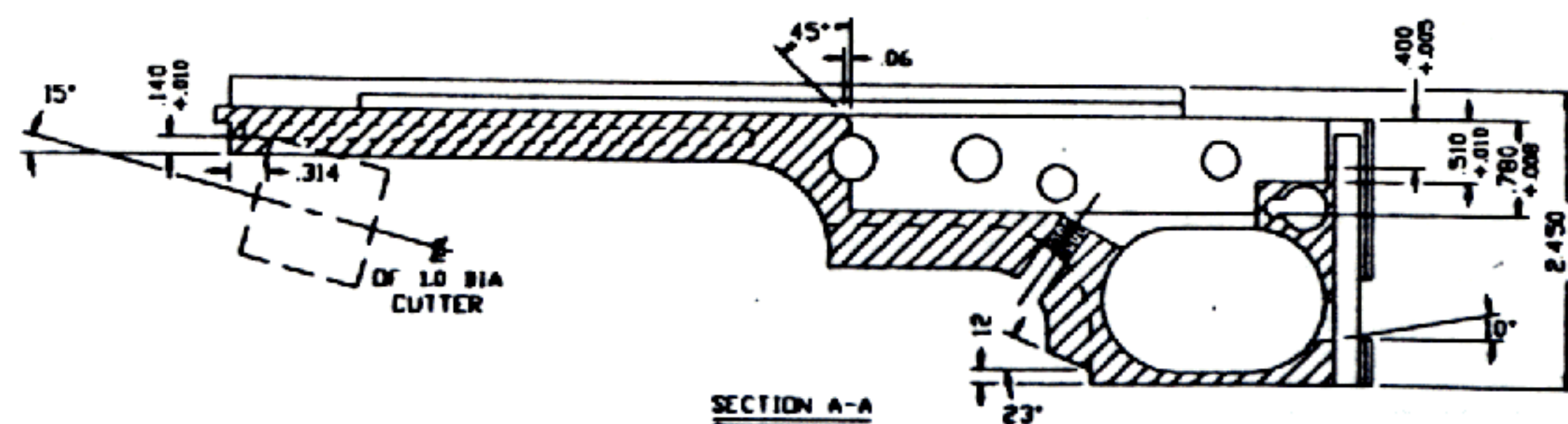
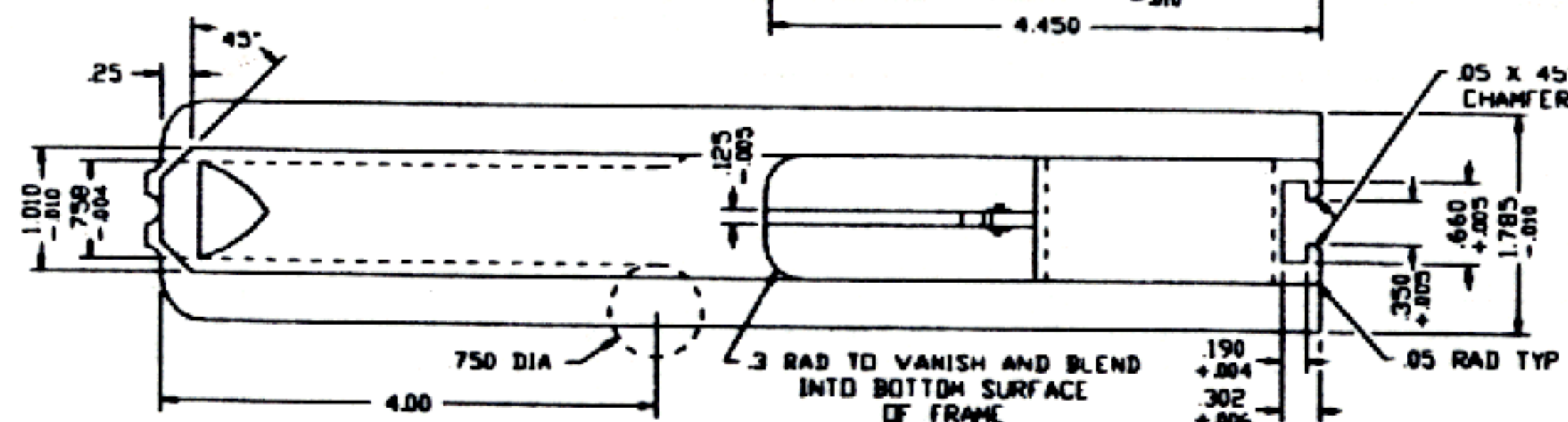
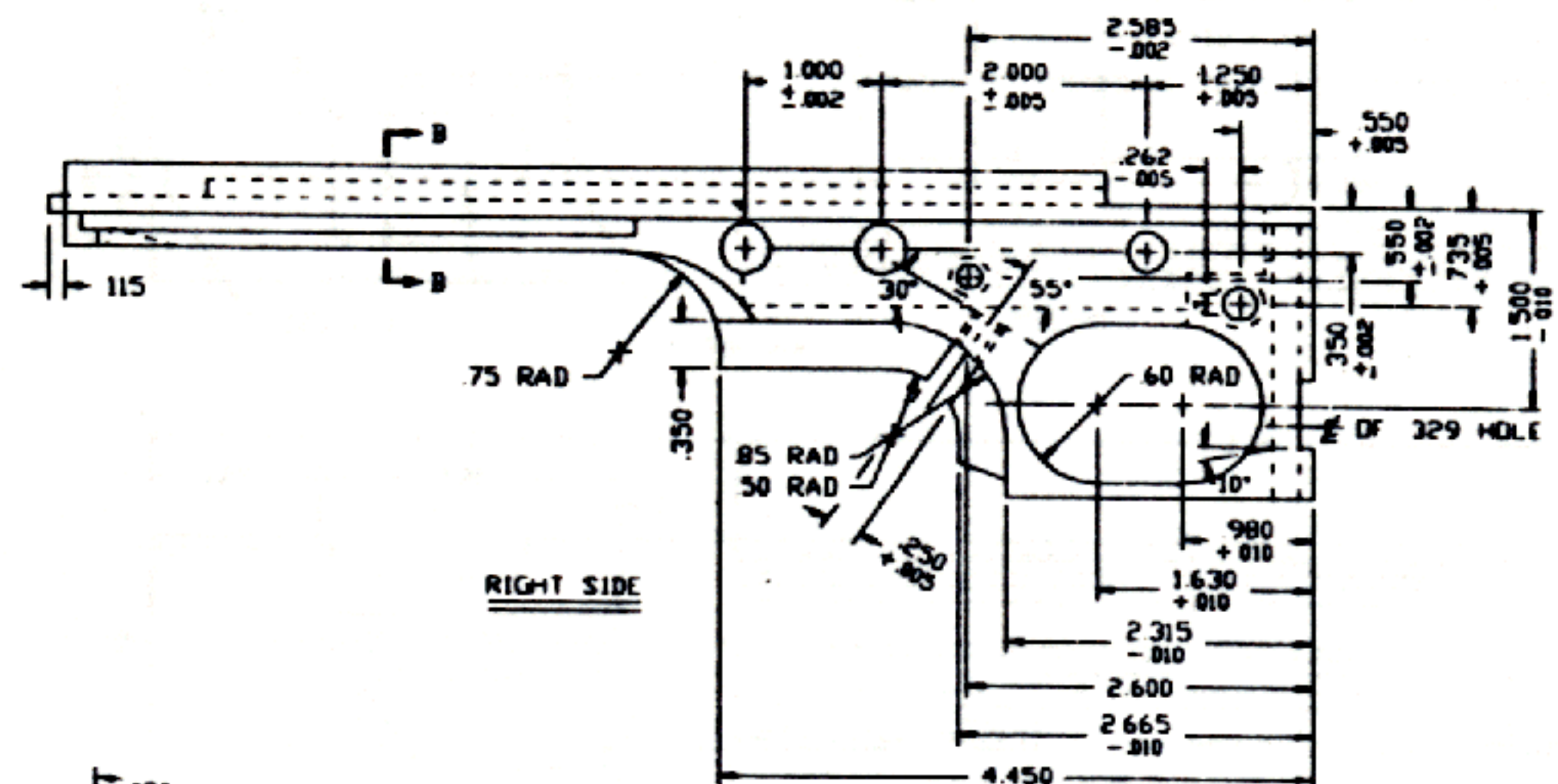
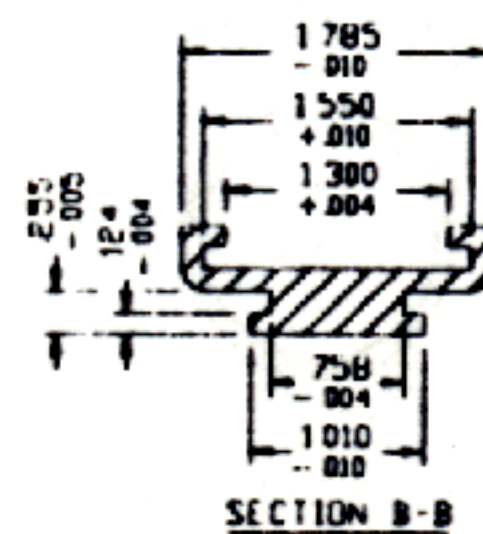
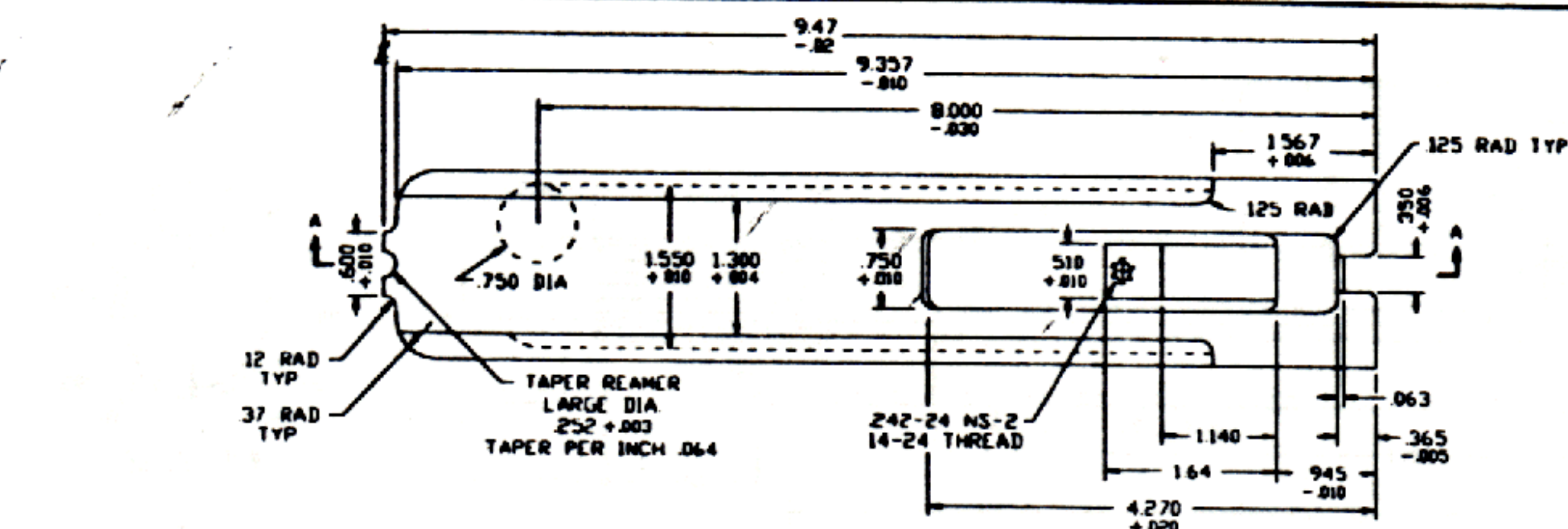
**RESTRICTED  
MATER A1**

**GENERAL NOTES AND SUGGESTIONS**

1. MATERIAL - 1018-4130 STEEL.
2. FINISH - PARKERIZE FOR ALL A-1'S  
BLUE FOR 2B COMMERCIAL  
BUT BY ALL MEANS SUIT YOURSELF.
3. BREAK ALL SHARP EDGES.
4. INSTEAD OF 126 RIVET HOLES I SUGGEST  
DRILL # 43 AND TAP # 4-48 THREADS  
AND ATTACH REAR SIGHT WITH BUTTON SOCKET CAP SCREWS  
FOR LETTERING REFER TO THE THOMPSON SUBMACHINE  
GUN BY ROGER COX.
5. CORRECTED FROM 1957 ORDNANCE PRINT WITH CORRECT  
DIMENSIONS OF A 1928 THOMPSON RECEIVER.

SCALE	DATE	REV.	TOLERANCES
FULL	SEE NOTE 1		ALL DIMENSIONS ± .005
	SEE NOTE 2		ALL DIMENSIONS ± .002
			ALL DIMENSIONS ± .001
			ANGLES ± .5°

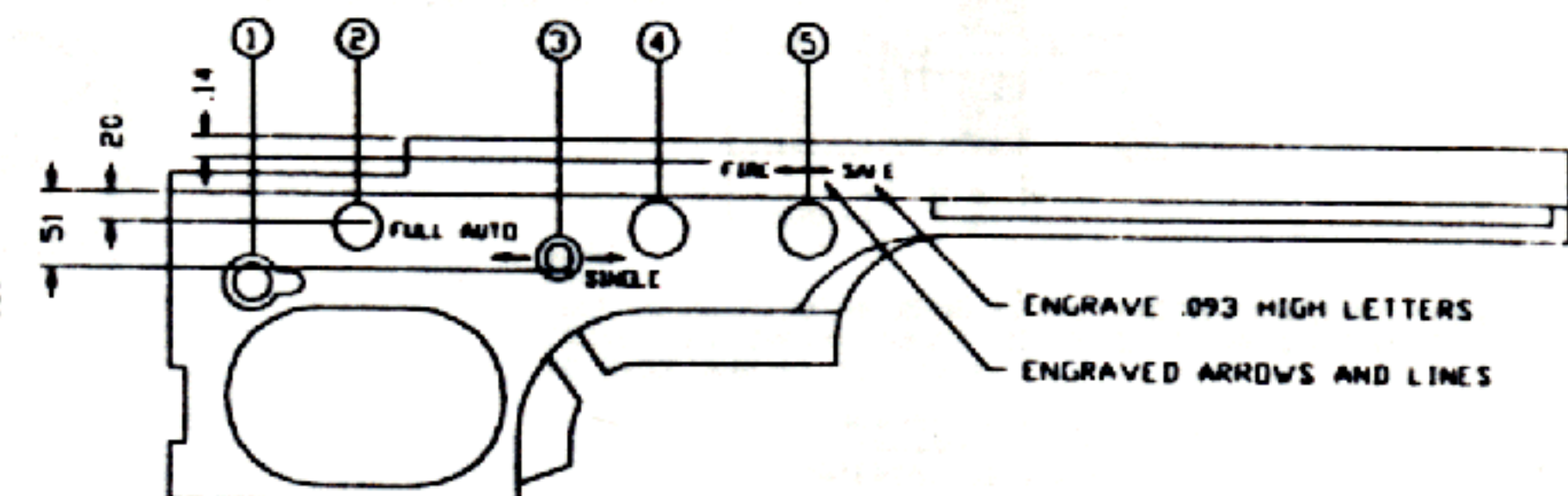
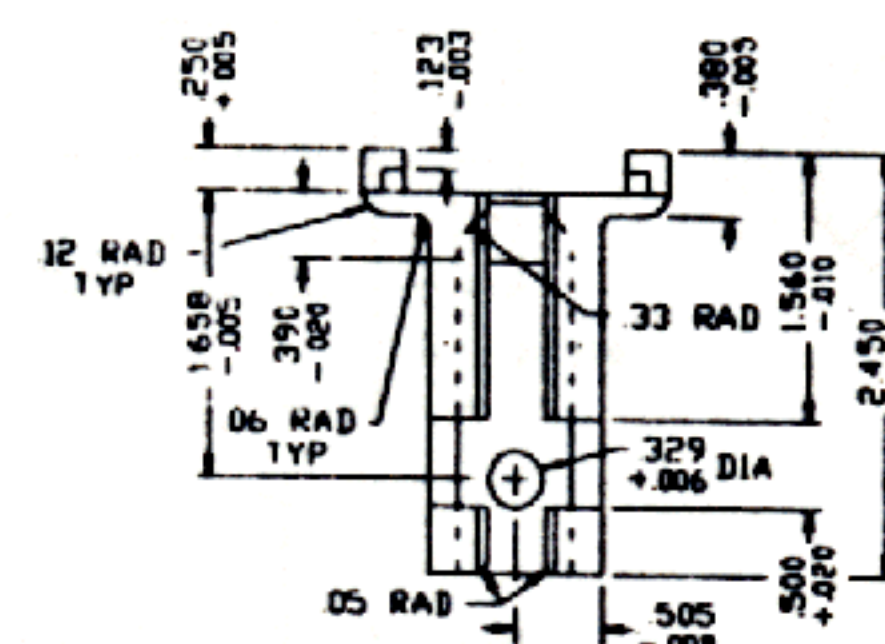




#### HOLE DRILLING SEQUENCE

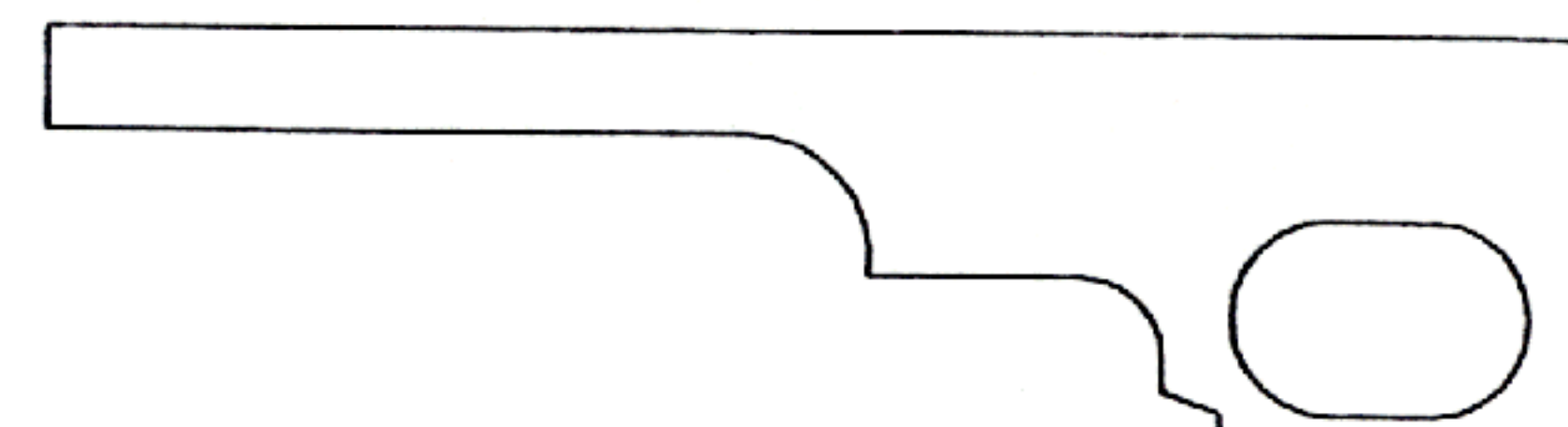
DRILL ALL HOLES BEFORE CUTTING POCKET

- 1 DRILL 5/32" X .875 DEEP AT 262 DIMENSION  
DRILL 1/4" THRU AT .550 DIMENSION  
DRILL 3/8" X .875 DEEP AT .550 DIMENSION
- 2 DRILL 5/16" THRU AT 1.250 DIMENSION
- 3 DRILL 7/8" (302) X 5/8" DEEP AT 2.585 DIMENSION  
DRILL #14 (182) THRU AT 2.585 DIMENSION
- 4 DRILL 3/8" THRU
- 5 DRILL 3/8" THRU



LOCATE LETTERS, ARROWS AND LINES AS DIMENSIONED AND SHOWN, THEN WHITE FILL

LEFT SIDE  
HOLE AND LETTERING PLACEMENT



TEMPLATE FOR ROUGH SAWING OF STEEL BLOCK

**CONFIDENTIAL**

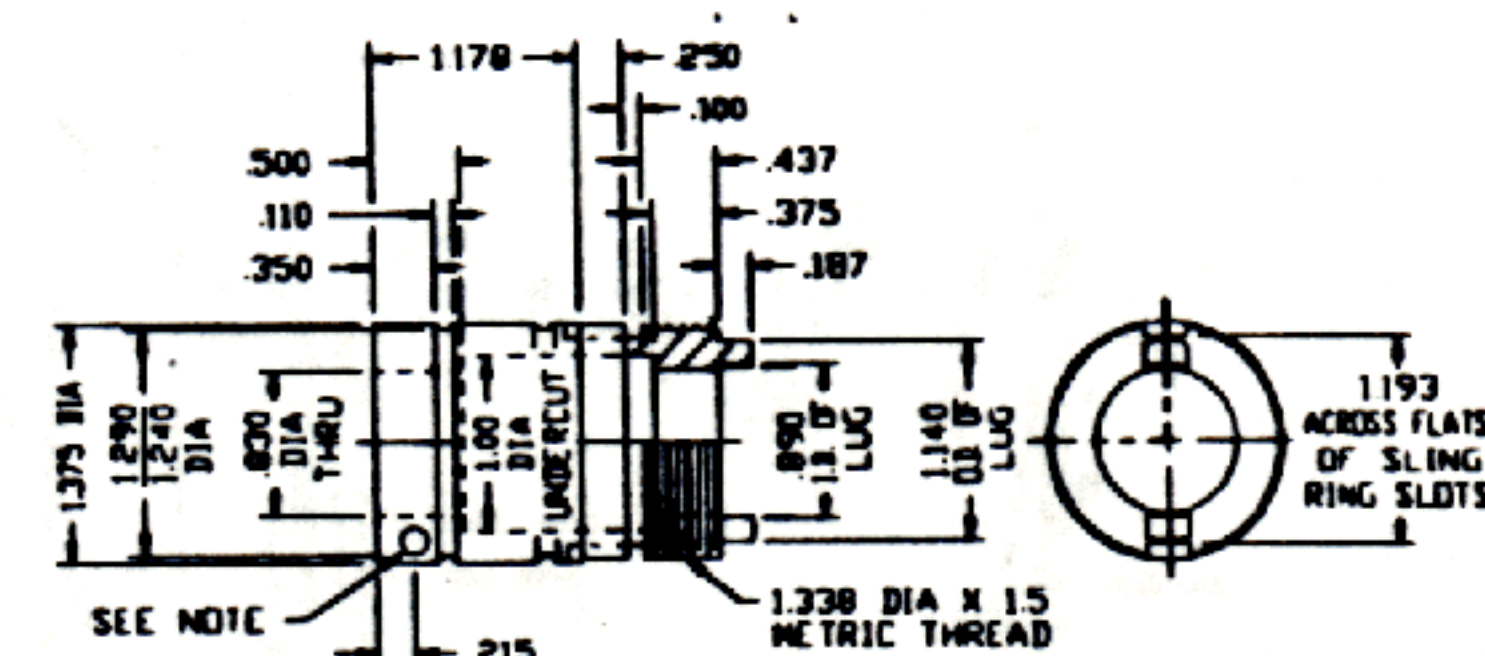
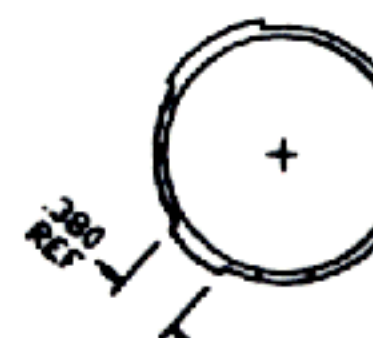
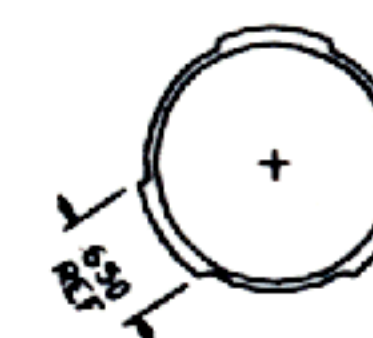
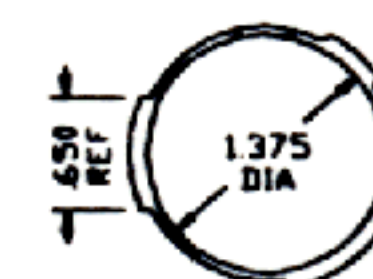
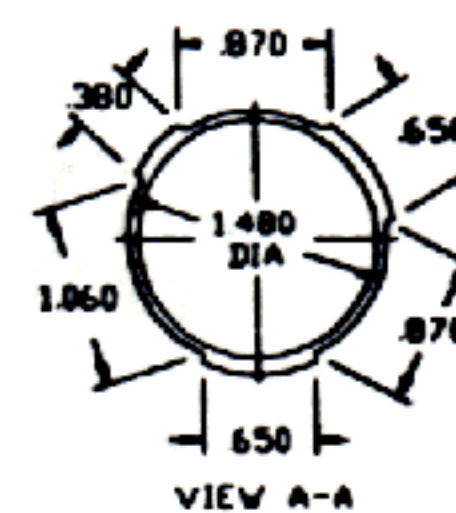
**RESTRICTED MATERIAL**

#### NOTE:

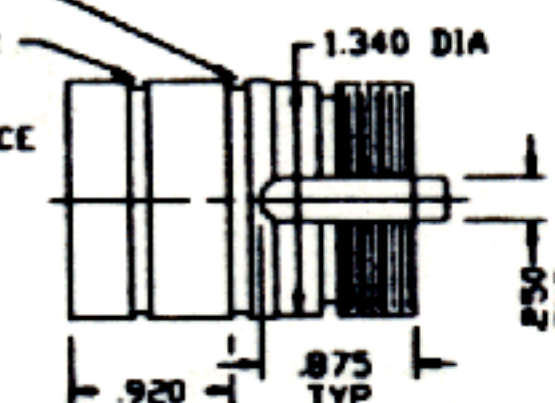
1 MATERIAL - 1018-4130 STEEL

SCALE: FULL	MATERIAL: SEE NOTE 1	CAD	TOLERANCES
FINISH	FINISH	DATE	DEC 31, 1997
TITLE: MODEL 1928 THOMPSON SUBMACHINE GUN TRIGGER FRAME	REV.	REV.	DEC 31, 1997
			ANGLES: ± .0°



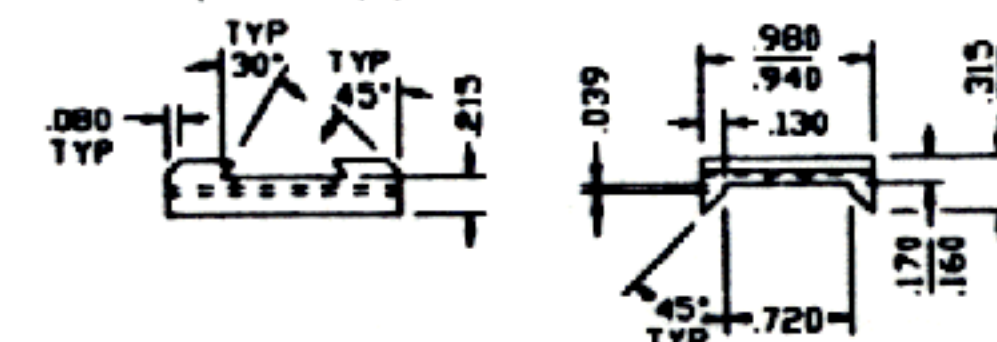
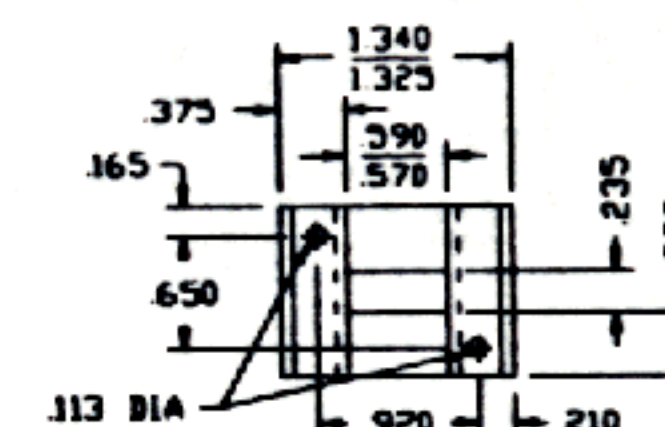


VERY EARLY WAR -  
MID WAR -  
LATE WAR NO GROOVES  
PART WAS SWAGED IN PLACE

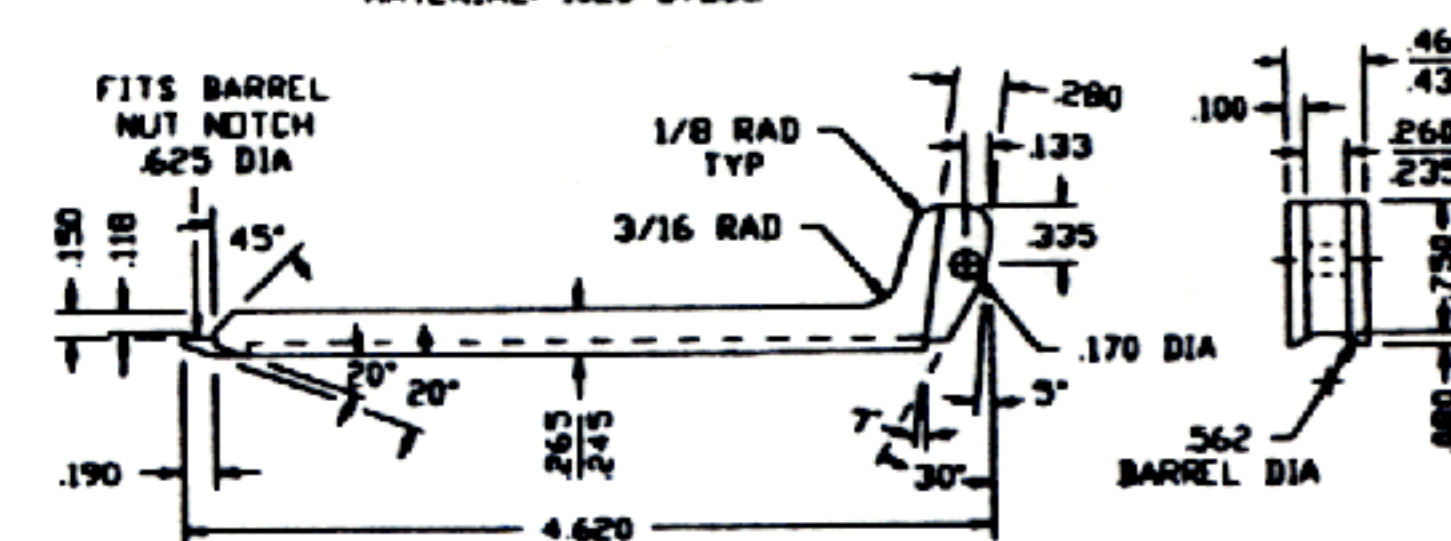


NOTE:  
HOLE IN MAGAZINE HOUSING IS THE FACTOR WHEN ASSEMBLED  
CROSS HOLE CHECKS ABOUT .215 THIS IS THE LAST HOLE  
TO DRILL AND AT ASSEMBLY.

BARREL BUSHING  
MATERIAL: 1020 STEEL



REAR SIGHT BASE  
MATERIAL: 1020 STEEL



EARLY GUNS MATERIAL WAS ALUMINUM  
FEW WERE STAMPED SHEET STEEL

RESTING BAR  
MATERIAL: 6061-T6 ALUMINUM

3. SLOTS ARE FORMED WITH A CUTTER .200 WIDE FULL RADIUS X .030 DEEP

**RESTRICTED**  
**MATERIAL**

**CONFIDENTIAL**

SCALE: FULL	NATURAL: SEE NOTE 1	CRS	TOLERANCES
PHS	FBIHQ: SEE NOTE 2	DATE	INCHES ± 1/8 FEET ± 1/4 FEET ± 1/4 ANGLES ± 30°
TITLE: MP-38 RECEIVER		REV.	NO.



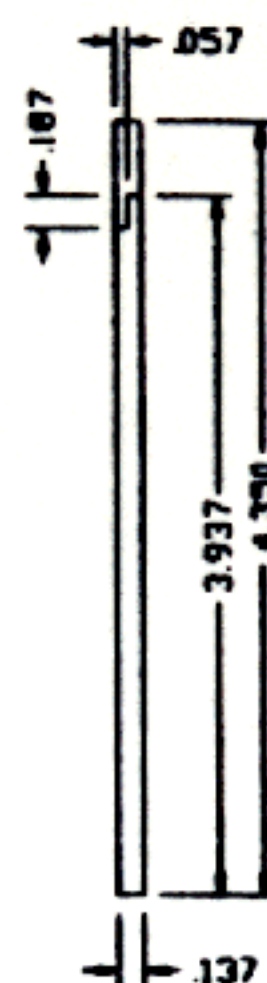








**PLATE 1**

[illegible]

SALE ORDER		
WOLE	DESCRIPTION	QTY
A	.375 DIA	
B	.128 DIA (#30 DRILL)	29
C	.250 DIA	1
D	.290 DIA	1
E	.082 DIA (#45 DRILL)	1

### NOTES:

1. MATERIAL- 4130, 4140, 4340 - PRE HEAT TREAT 28-32 R/C  
2. FINISH- BLUE  
3. ALL Ø30 DRILLED HOLES ARE FOR .125 DIA RIVETS

**CONFIDENTIAL**

SCALE: FULL	MATERIAL: SEE NOTE 1	CBS	TOLERANCES: H/C 3 P L 1/8 H/C 3 P L 1/8 H/C 3 P L 1/8 H/C 3 P L 1/8
DATE	FINISH: SEE NOTE 2	DATE	
TITLE: VICKERS RIGHT SIDE PLATE		REV.	NO.



## **LIST OF PARTS SUPPLIERS**

**wholesale guns and ammo, inc.**  
**232 blydenburgh rd.**  
**central islip, NY 11722**

**[www.gunsnammo.com](http://www.gunsnammo.com)**

**international military antiques , inc.**  
**p.o.box 256 millington ,NJ 07946**

**[www.ima-usa.com](http://www.ima-usa.com)**

**inter ordnance of america l.p.**  
**3305 westwood industrial drive**  
**monroe , NC 28110**

**[www.inter-ordnance.com](http://www.inter-ordnance.com)**

**sarco , inc.**  
**323 union st. p.o. box 98**  
**stirling , NJ 07980**

**jeffs shooters supply**  
**p.o.box 1054 trussville , AL 35173**

**rpb industries**  
**p.o.box 367 avondale est. GA 30002**

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**1- scale print of MK V sten**

**1- scale print of MAC 10 upper**

**1- scale print of MAC 10 lower**

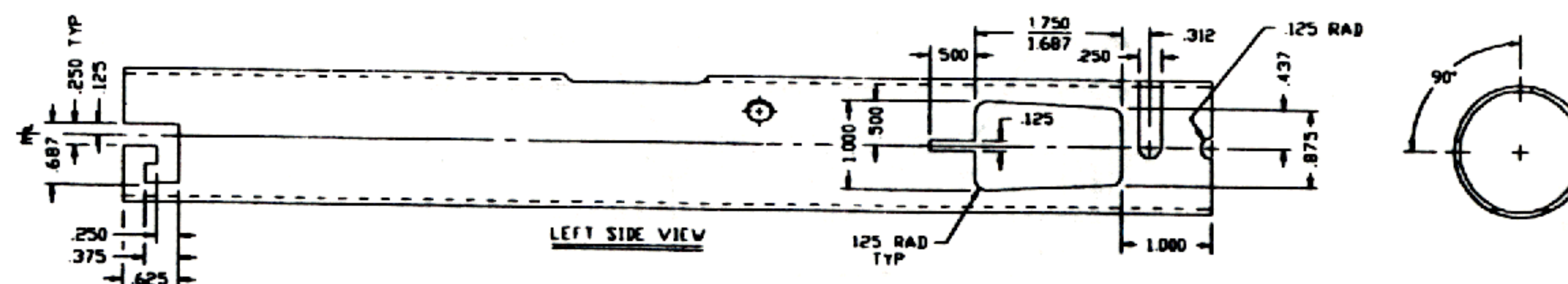
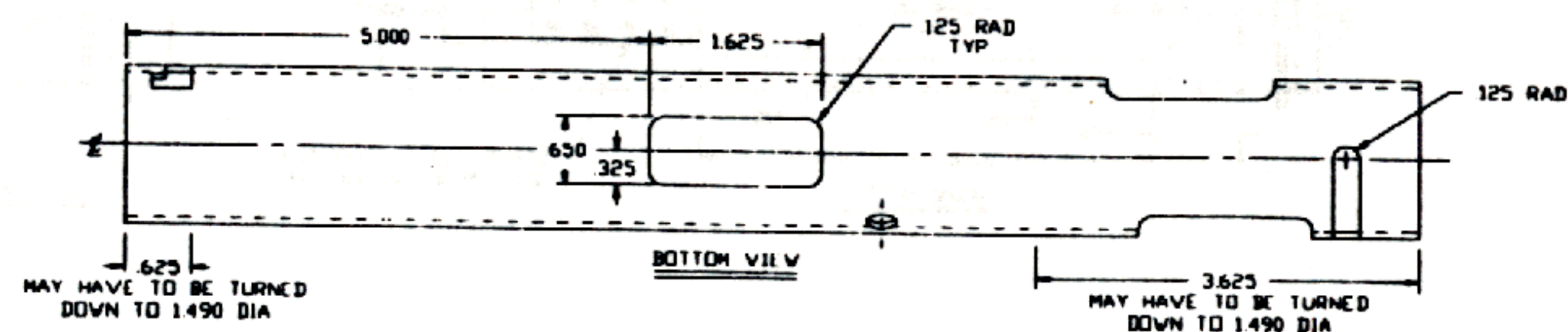
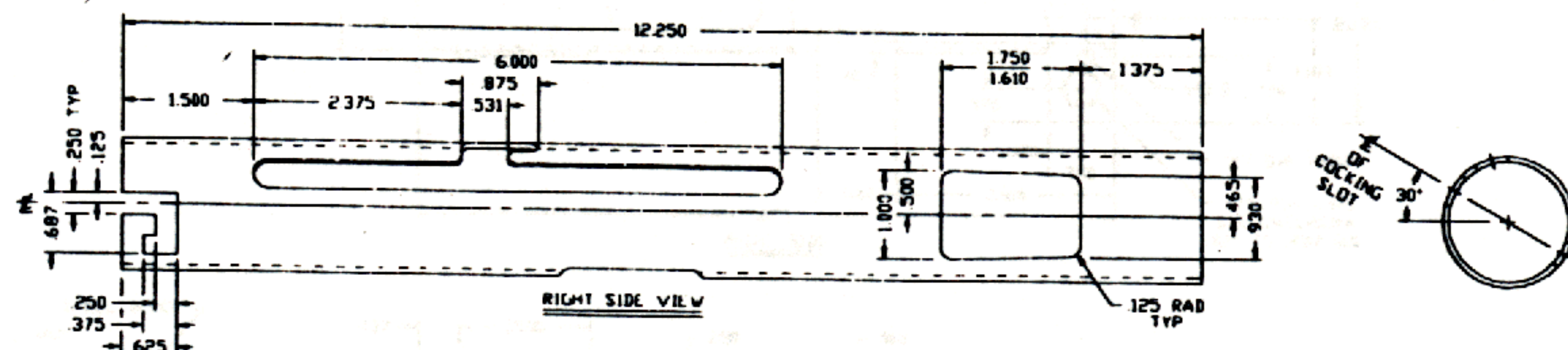
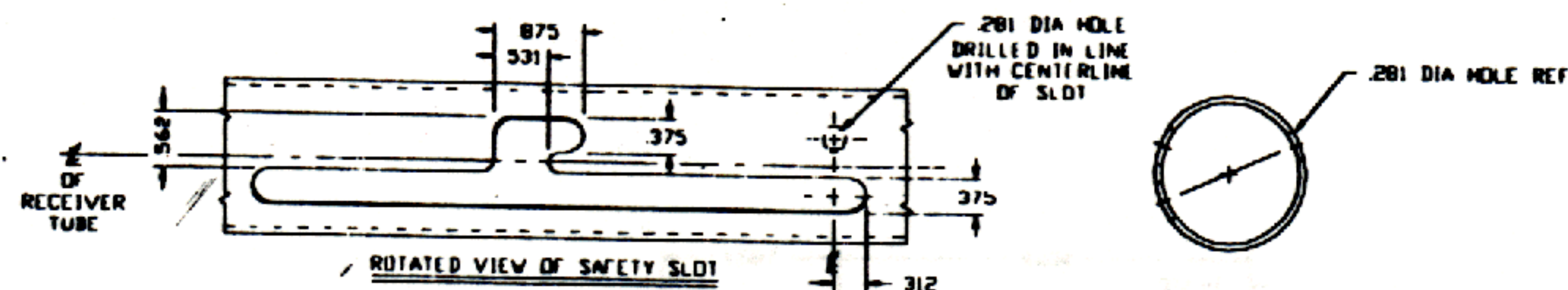
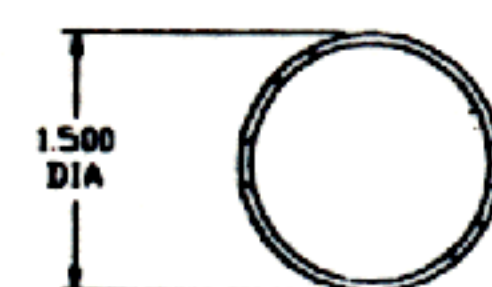
**1- scale print of AUSTIN MK I**

**1- scale print of BERETTA 38A AND 38/44**

**1- scale print of MADSEN MODEL 1950**

**PARTS SUPPLIERS ON LAST PAGE**





- NOTES**
- 1 MATERIAL - MILD STEEL SEAMLESS, DRAWN OVER MANDREL 1.500 O.D X .049, .055, .062 WALL.
  - 2 FINISH - PAINT BLACK.
  - 3 SHORTCUT TO CONSTRUCTION CAN BE ACCOMPLISHED BY CUTTING TUBE FLUSH TO REAR SIGHT RING AND FLUSH TO BARREL BUSHING IF THIS METHOD IS USED, A REDUCTION IN LENGTH MUST ALSO BE MADE.
  - 4 625 AND 3.625 DIMENSIONS MAY NEED TO BE TURNED DOWN TO 1.490 DIA TO FIT MAGAZINE HOUSING AND REAR SIGHT RING.

**RESTRICTED  
MATERIAL**

**CONFIDENTIAL**

SCALE: FULL	MATERIAL: SEE NOTE 1	CAS	REVISIONS
DATE:	FINISH: SEE NOTE 2	DATE:	REV. 1
TITLE: STEN MK-V RECEIVER	REV.	DATE:	REV. 2
		DATE:	REV. 3
		DATE:	REV. 4

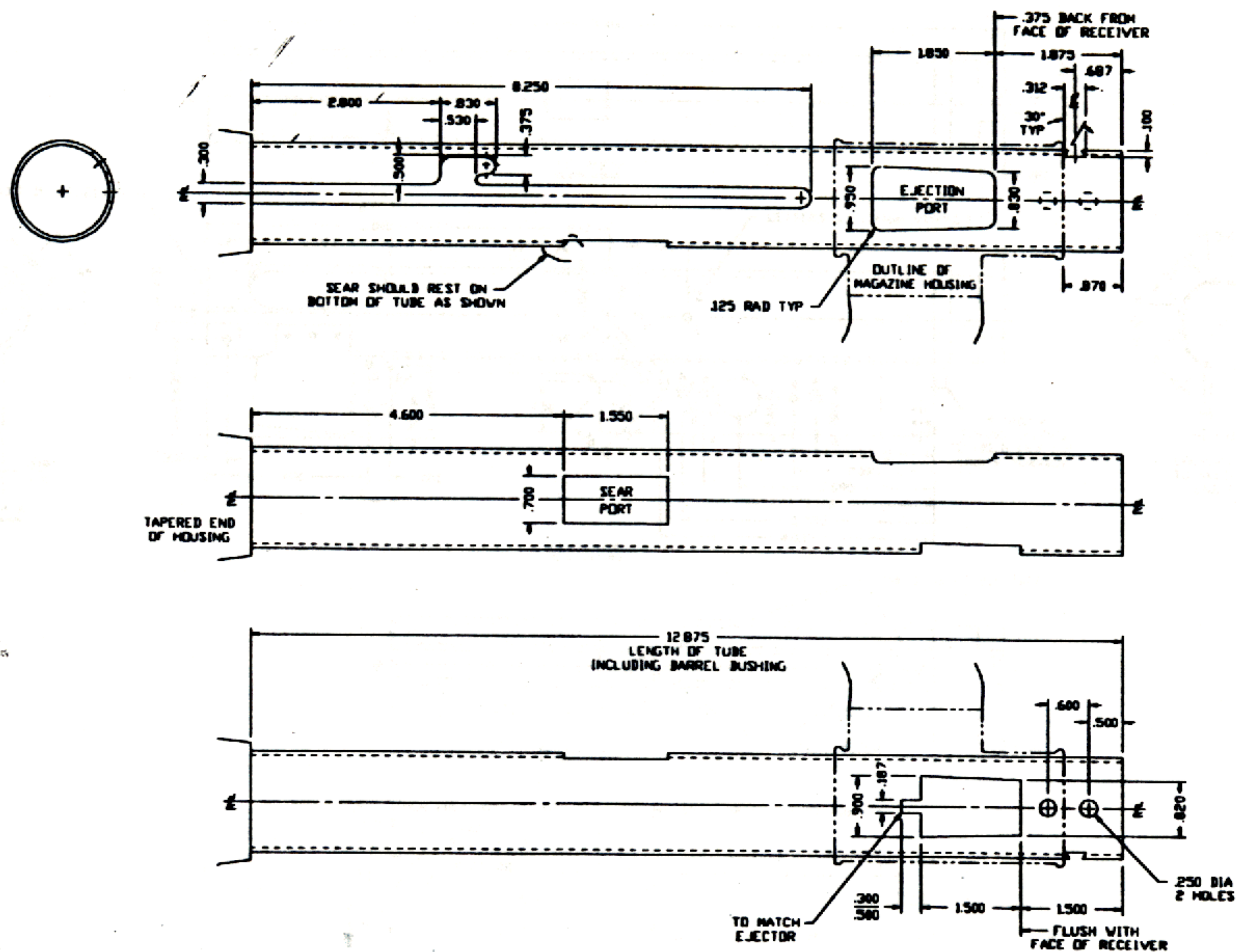












# NOTES-

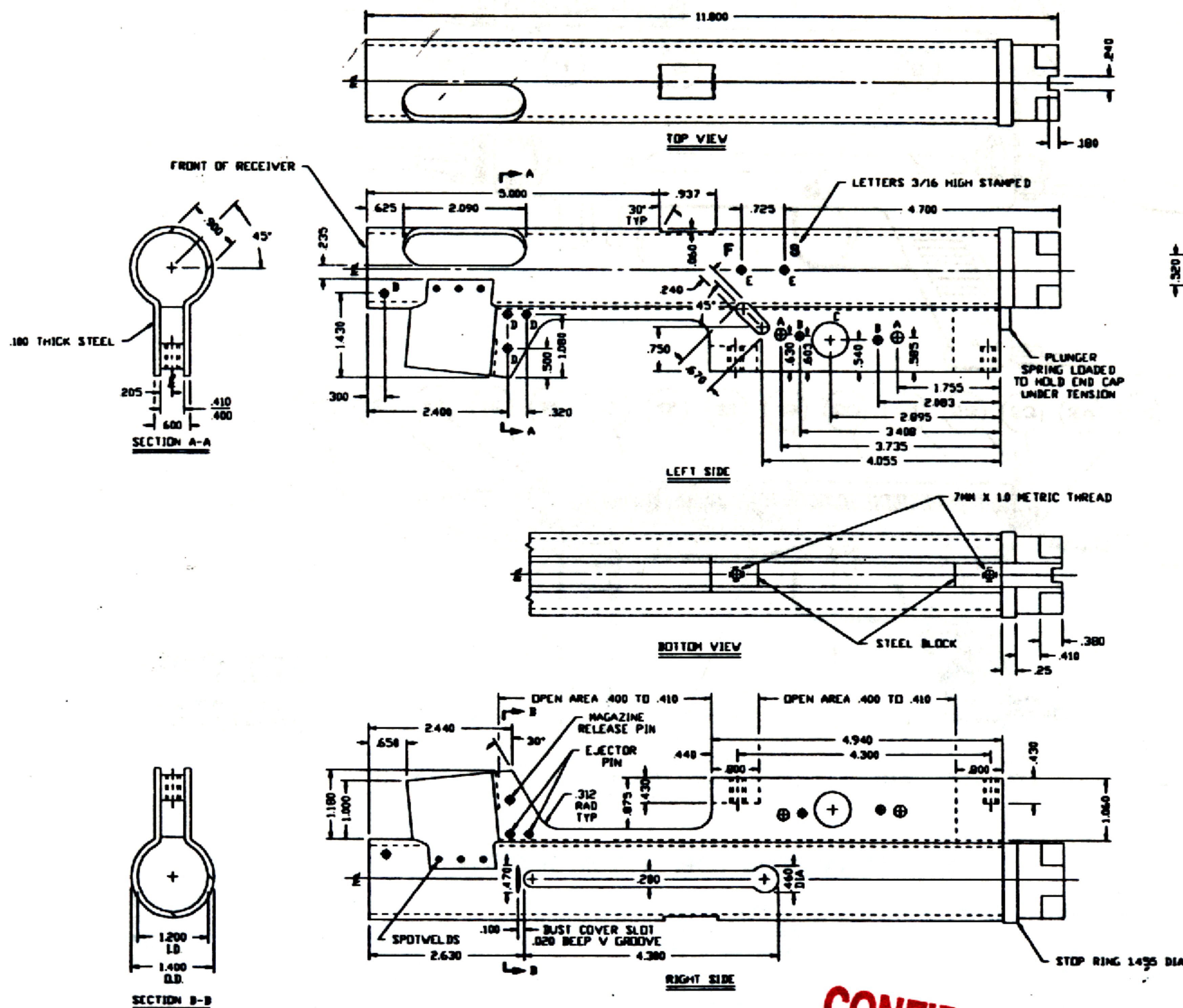
1. MATERIAL- 1.500 O.D. X .065 WALL B.D.M. STEEL TUBE
2. FINISH- PARKERIZE AND PAINT FLAT BLACK

**RESTRICTED  
MATERIAL**

**CONFIDENTIAL**

SCALE	FULL	DATE	10/1/54	REV.	1
BY	W. J. R.	DATE	10/1/54	REV.	1
CHECKED	W. J. R.	DATE	10/1/54	REV.	1
APPROVED	W. J. R.	DATE	10/1/54	REV.	1
TITLE	AUSTIN MK I RECEIVER				





DRILL CHART		
NO.	DESCRIPTION	QTY
A	.201 DIA THRU	2
B	.145 DIA THRU	3
C	.610 DIA THRU	1
D	.135 DIA THRU	3
E	.145 DIA X .030 DEEP	2

#### NOTES:

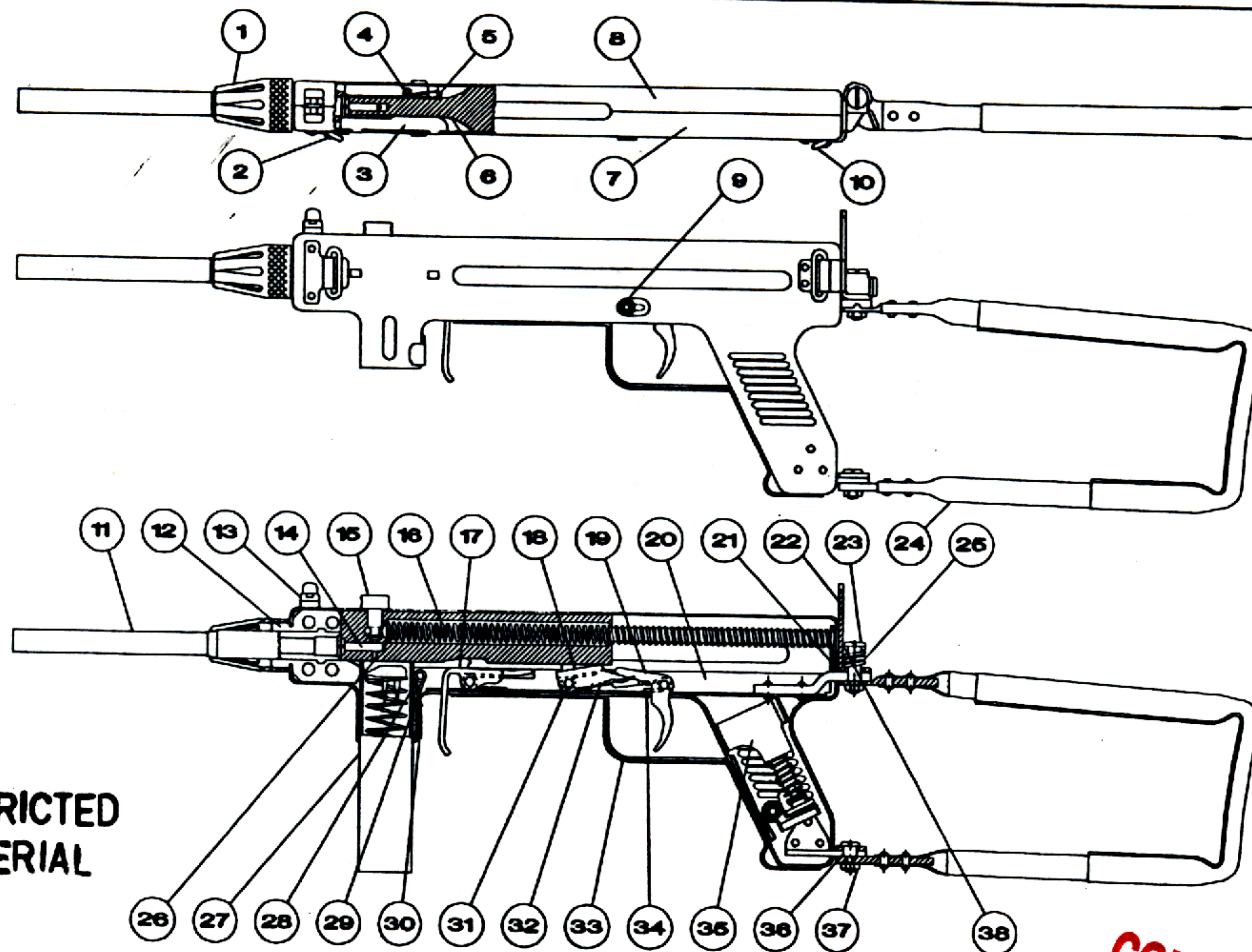
1. MATERIAL - 1.500 O.D. X 1.187 I.D. STEEL DOM. TUBE
2. FINISH - BLUE
3. FRONT OF RECEIVER TUBE INTERNALLY THREADED TO MATCH BARREL THREAD.
4. IF REBUILDING RECEIVER USING PARTS KIT DO THE FOLLOWING
  - A. TRIM TUBING AWAY FROM TRIGGER HOUSING.
  - B. TURN TUBE (NEW) TO 1.400 OUTSIDE DIAMETER.
  - C. BORE TUBE (NEW) TO 1.200 INSIDE DIAMETER. THEN SLOT BOTTOM OF TUBE TO .410 WIDTH.
  - D. FIT TUBE TO EXISTING REMAINS.
  - E. TACK WELD IN PLACE.
  - F. FIT END CAP RETAINING END TO TUBE AND TACK WELD.
  - G. CHECK FOR ALIGNMENT WITH TRIGGER HOUSING AND BUTT STOCK BEFORE FINAL WELD.
  - H. FINISH WELD AND FINAL MACHINE.

RESTRICTED  
MATERIAL

CONFIDENTIAL

SCALE	FULL	DATE	REV.	REVISIONS
DATE	SEE NOTE 1	DATE		REV. 1
DATE	SEE NOTE 2	DATE		REV. 2
TITLE	BERETTA 30A AND 30/44 RECEIVER			REV. 3





**RESTRICTED  
MATERIAL**

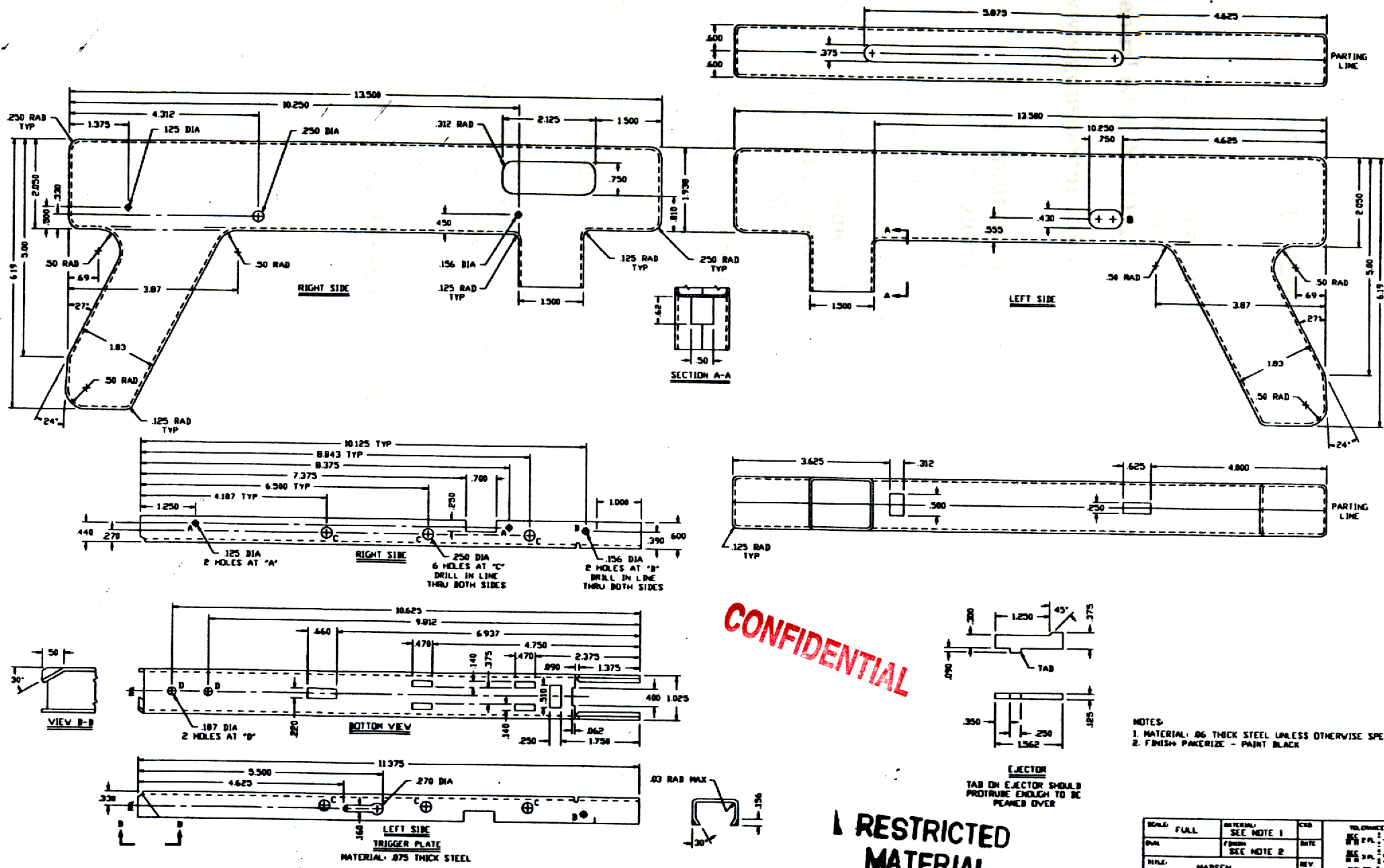
**CONFIDENTIAL**

# **MADSEN MODEL 1950 SUBMACHINE GUN**

- |                      |                          |                                   |                                |
|----------------------|--------------------------|-----------------------------------|--------------------------------|
| 1 BARREL BEARING NUT | 11 BARREL                | 21 RETURN SPRING GUIDE (COMPLETE) | 30 MAGAZINE CATCH              |
| 2 SLING SWIVEL       | 12 BARREL BEARING        | 22 REAR SIGHT PLATE               | 31 TRIGGER ROD PIN             |
| 3 EJECTOR            | 13 FRONT SIGHT           | 23 SHOULDER PIECE BOLT (UPPER)    | 32 TRIGGER ROD SPRING          |
| 4 EXTRACTOR PIN      | 14 FIRING PIN            | 24 SHOULDER PIECE                 | 33 TRIGGER GUARD               |
| 5 EXTRACTOR          | 15 COCKING HANDLE        | 25 SHOULDER PIECE SPRING          | 34 TRIGGER SPRING              |
| 6 BREECHBLOCK        | 16 RETURN SPRING         | 26 FIRING PIN RIVET               | 35 MAGAZINE LOADING APPARATUS  |
| 7 FRAME HALF (LEFT)  | 17 BREECH BLOCK RETAINER | 27 MAGAZINE                       | 36 SHOULDER PIECE BOLT (LOWER) |
| 8 FRAME HALF (RIGHT) | 18 TRIGGER ROD           | 28 MAGAZINE CATCH PIN             | 37 SHOULDER PIECE BOLT NUT     |
| 9 SAFETY CATCH       | 19 TRIGGER               | 29 MAGAZINE CATCH SPRING          | 38 SHOULDER PIECE LOCK         |
| 10 SLING SWIVEL      | 20 TRIGGER PLATE         |                                   |                                |

SCALE:	INTERNAL:	DATE:	TOLERANCES:
FIN:	FINISH:	DATE:	AS SHOWN
TITLE:	MADSEN MODEL 1950 SUBMACHINE GUN		REV.:
			NO.







## **LIST OF PARTS SUPPLIERS**

**wholesale guns and ammo, inc.**  
**232 blydenburgh rd.**  
**central islip, NY 11722**

**[www.gunsnammo.com](http://www.gunsnammo.com)**

**international military antiques , inc.**  
**p.o.box 256 millington ,NJ 07946**

**[www.ima-usa.com](http://www.ima-usa.com)**

**inter ordnance of america l.p.**  
**3305 westwood industrial drive**  
**monroe , NC 28110**

**[www.inter-ordnance.com](http://www.inter-ordnance.com)**

**sarco , inc.**  
**323 union st. p.o. box 98**  
**stirling , NJ 07980**

**jeffs shooters supply**  
**p.o.box 1054 trussville , AL 35173**

**rpb industries**  
**p.o.box 367 avondale est. GA 30002**



## **TABLE OF CONTENTS**

**1- scale print of RUSSIAN PPSH-41**

**1- scale print of YUOGOSLAV 49/57**

**1- scale print of AMERICAN 180**

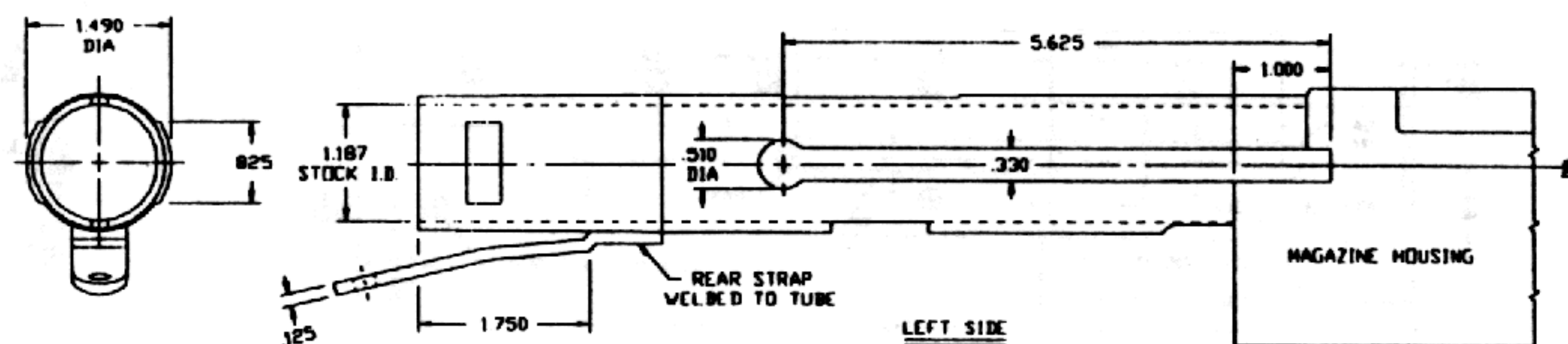
**1- scale print of BROWNING 1919A4/A6  
right and left sides**

**PARTS SUPPLIERS ON LAST PAGE**

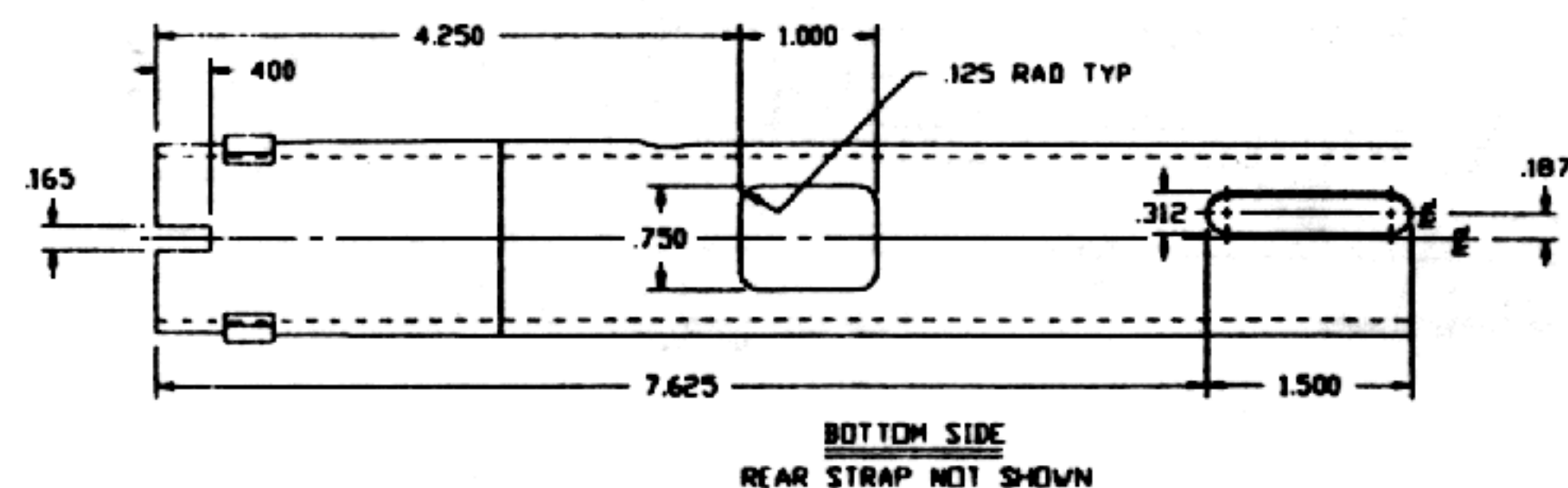








**CONFIDENTIAL**



## NOTES

1. MATERIAL - 1.300 O.D X 1.107 I.D DQ.M. STEEL TUBE
2. FINISH- BLUE
3. CALIBER- 7.62 TOKAREV
4. THE ORIGINAL RECEIVER WAS THE FULL LENGTH OF GUN  
IT WAS MADE FROM ROLLED STEEL AND WELDED FULL LENGTH.  
THE HOUSING WAS BRAZED IN PLACE AND ALL VOIDS  
WERE FILLED WITH BRASS.
5. THIS RECEIVER TUBE IS CUT TO A LENGTH AND BUTT WELDED  
TO EXISTING PORTION OF RECEIVER TUBE.  
FINAL OVERALL LENGTH TO BACK OF MAGAZINE HOUSING SHOULD BE 9.125

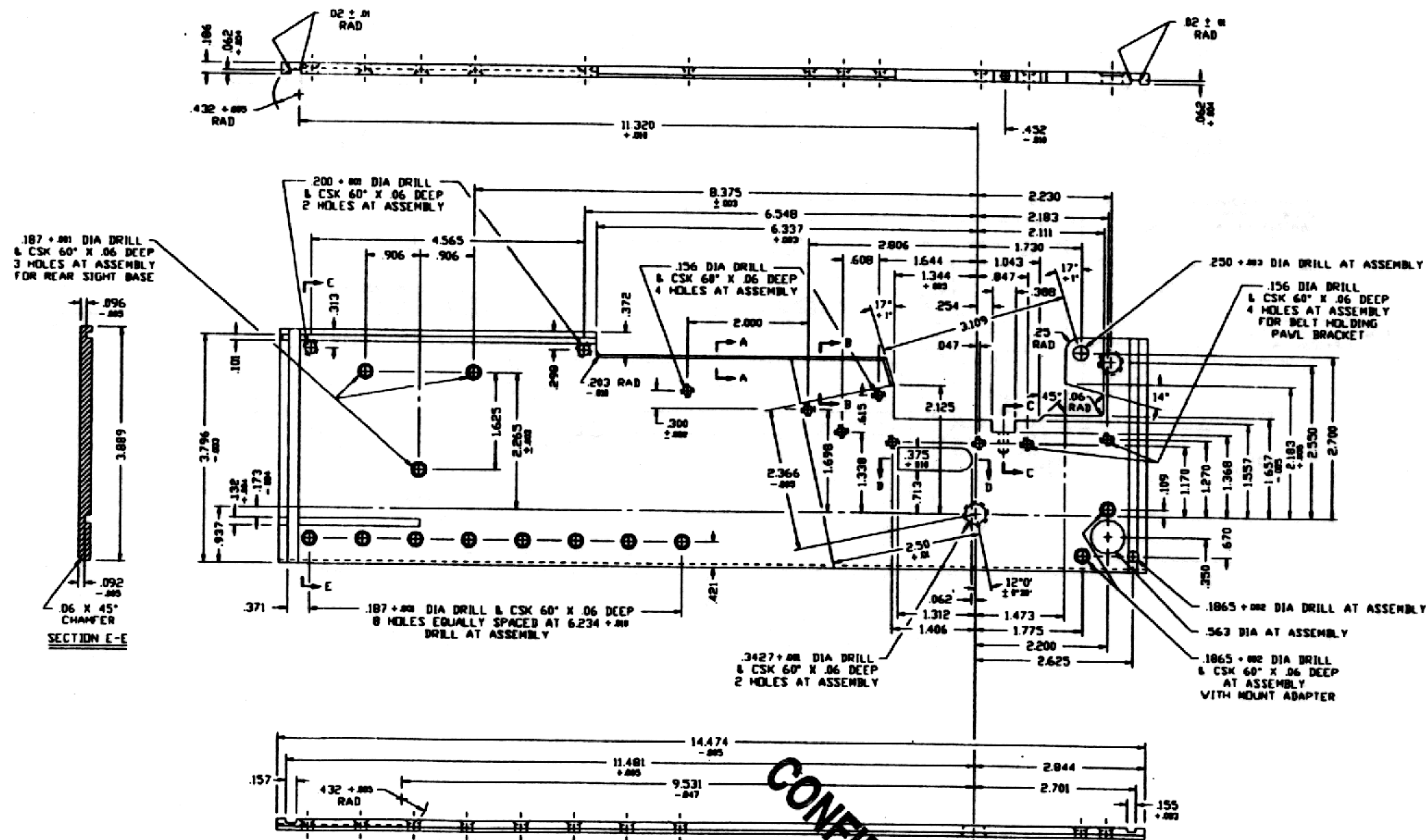
**RESTRICTED  
MATERIAL**

SCALE	FULL	INTERNAL	SEE NOTE 1	CRB		TOLEANCE	
DATA		EXTERNAL	SEE NOTE 2	DATE		SEC	2 PL. 10
TITLE				REV.		ALC	3 PL. 100
YUGOSLAV 49/57 RECEIVER						ANAL	2 PL. 10

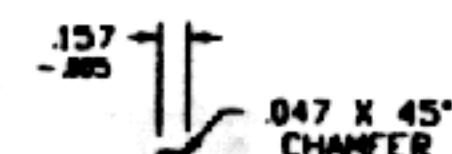




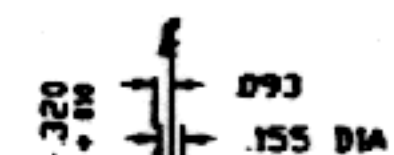




SECTION A-A



SECTION B-B



SECTION C-C



SECTION D-D

RESTRICTED  
MATERIAL

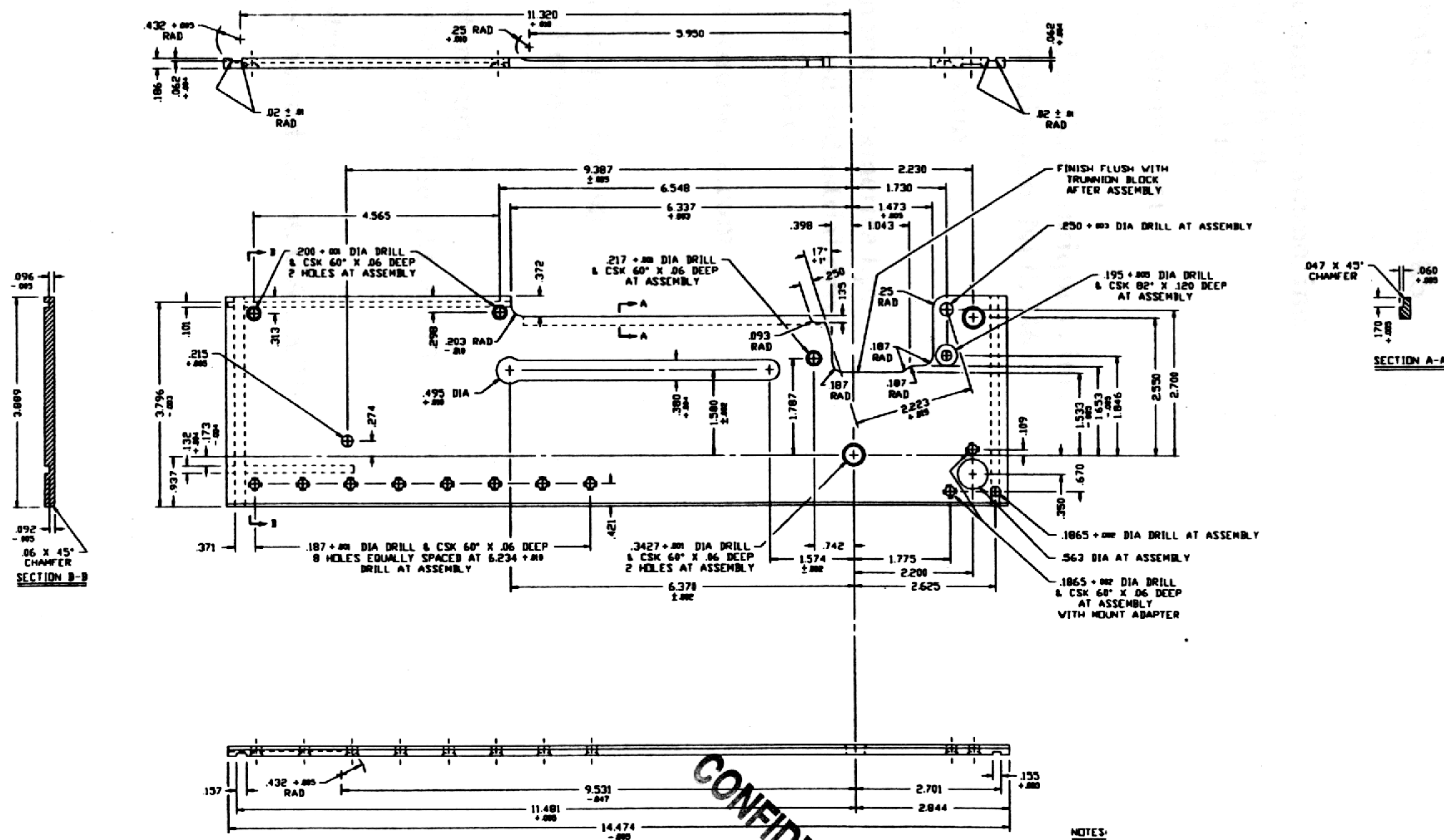
CONFIDENTIAL

NOTES:

1. MATERIAL- 4130 PLATE OR OH. FLAT GROUND STOCK
2. FINISH- PARKERIZE
3. ORIGINAL MATERIAL STEEL FS4042, FS4047, FS4640 PER MIL SPEC 00-S-624
4. HEAT TREAT REAR END FOR ONE INCH ROCKWELL "C"43-49  
ANNEAL AROUND TWO HOLES.

DATE	FULL	MATERIAL	SEE NOTE 1	CHK	REVISIONS
DATE		FORM	SEE NOTE 2	DATE	REV. 1
TITLE	BROWNING M919A4 AND A6	REV.			REV. 2
	LEFT HAND SIDE PLATE				REV. 3
					REV. 4





RESTRICTED  
MATERIAL

CONFIDENTIAL

- NOTES:
1. MATERIAL - 4130 PLATE OR OH. FLAT GROUND STOCK
  2. FINISH - PARKERIZE
  3. ORIGINAL MATERIAL STEEL FS4042, FS4047, FS4640 PER MIL SPEC QQ-S-624
  4. HEAT TREAT REAR END FOR ONE INCH ROCKWELL "C" 43-49 ANNEAL AROUND TWO HOLES.

SCALE: FULL	MATERIAL: SEE NOTE 1	CRS	TOLERANCES:
DRAWN	DATE	REV.	AS SHOWN
TITLE: BROWNING M919A4 AND A6 RIGHT HAND SIDE PLATE	REV.	NO.	AS SHOWN



## **LIST OF PARTS SUPPLIERS**

**wholesale guns and ammo, inc.  
232 blydenburgh rd.  
central islip, NY 11722**

**[www.gunsnammo.com](http://www.gunsnammo.com)**

**international military antiques , inc.  
p.o.box 256 millington ,NJ 07946**

**[www.ima-usa.com](http://www.ima-usa.com)**

**inter ordnance of america l.p.  
3305 westwood industrial drive  
monroe , NC 28110**

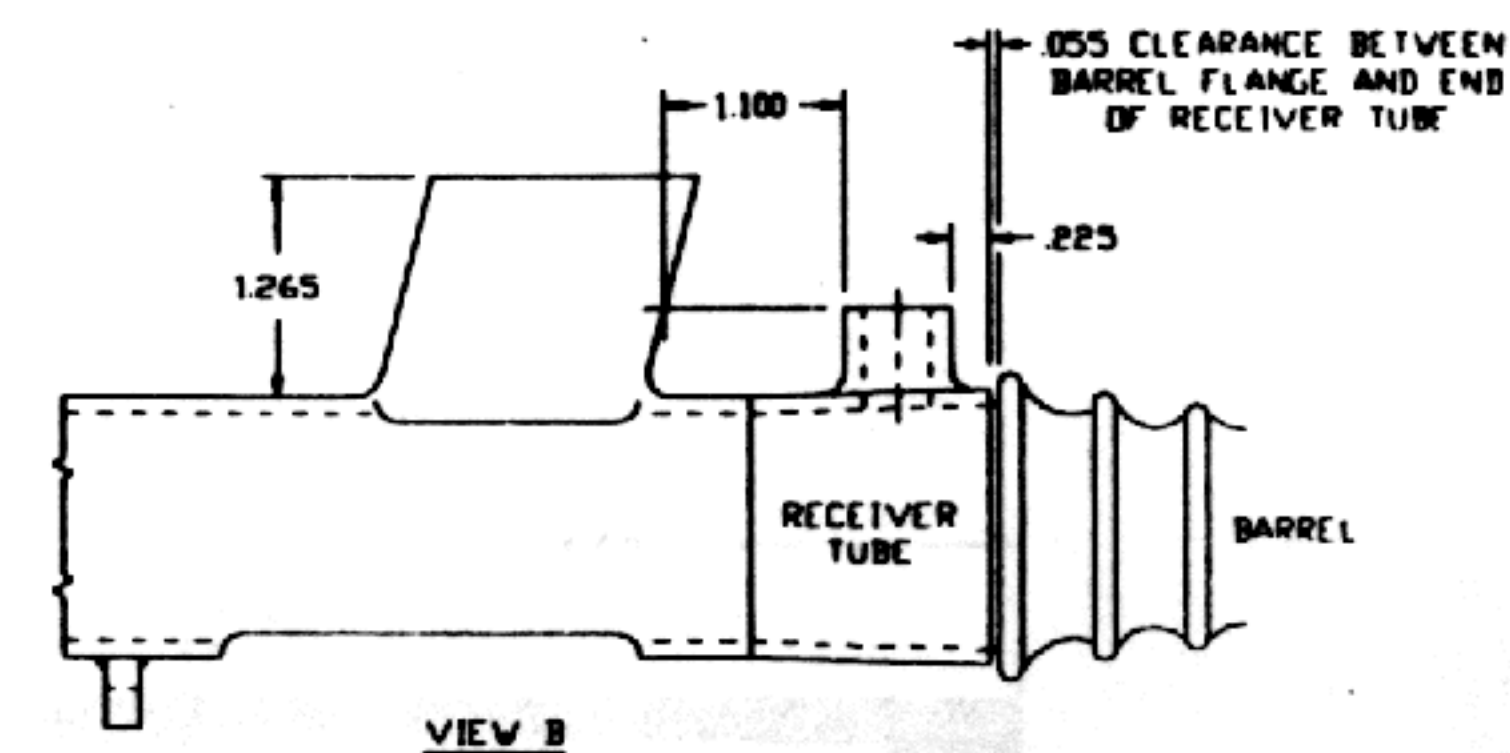
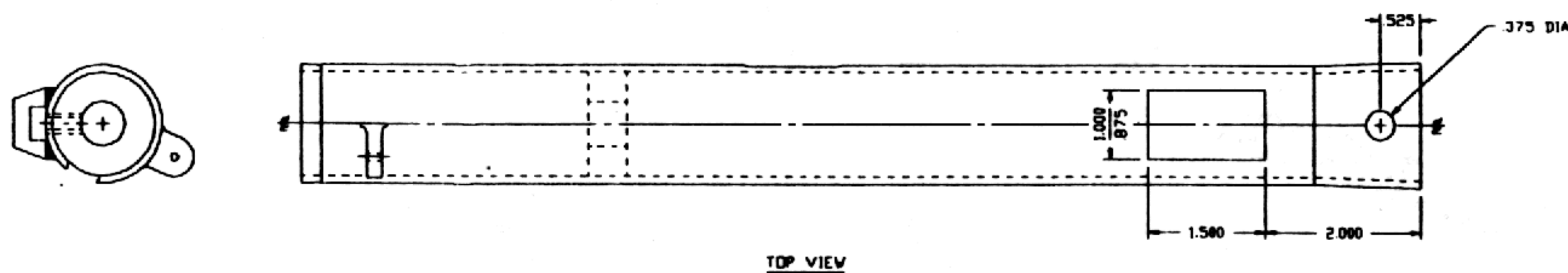
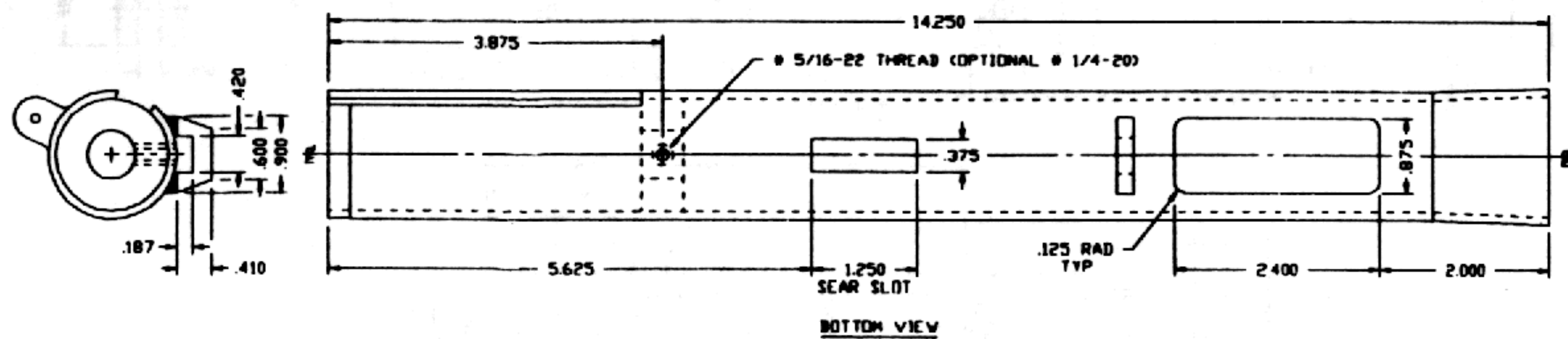
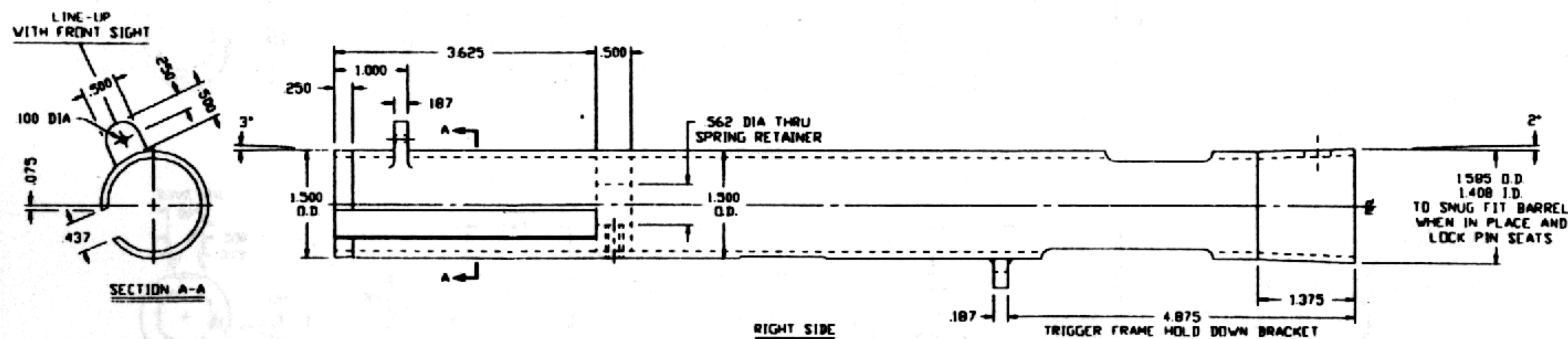
**[www.inter-ordnance.com](http://www.inter-ordnance.com)**

**sarco , inc.  
323 union st. p.o. box 98  
stirling , NJ 07980**

**jeffs shooters supply  
p.o.box 1054 trussville , AL 35173**

**rpb industries  
p.o.box 367 avondale est. GA 30002**





#### NOTES

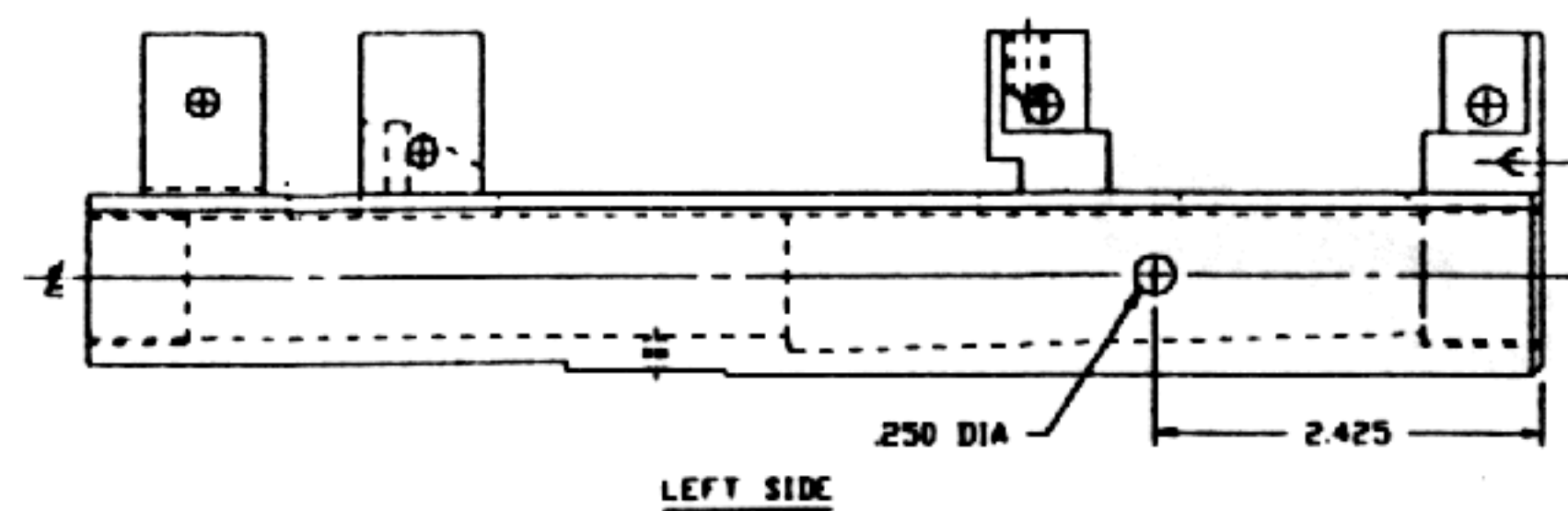
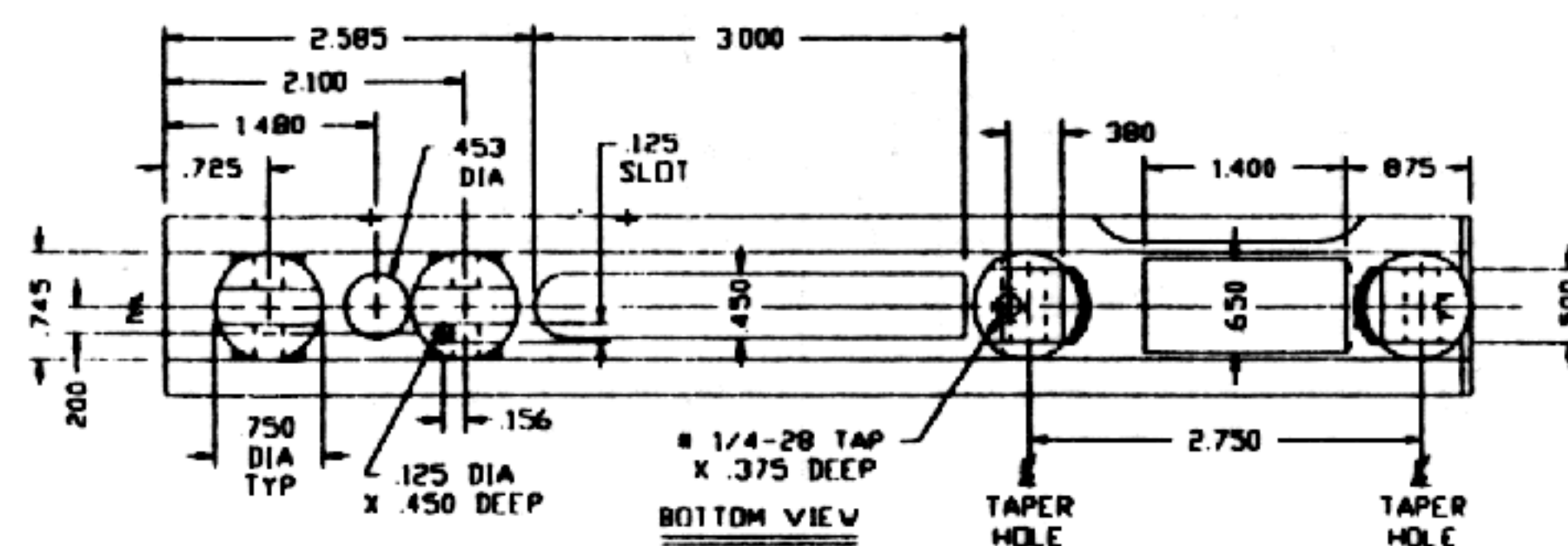
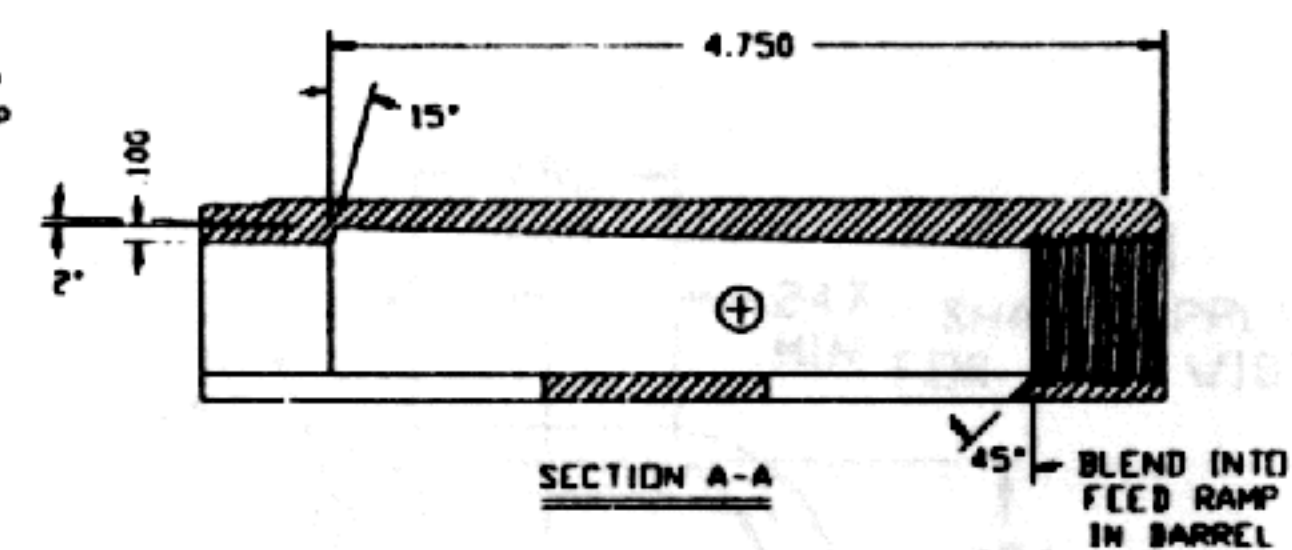
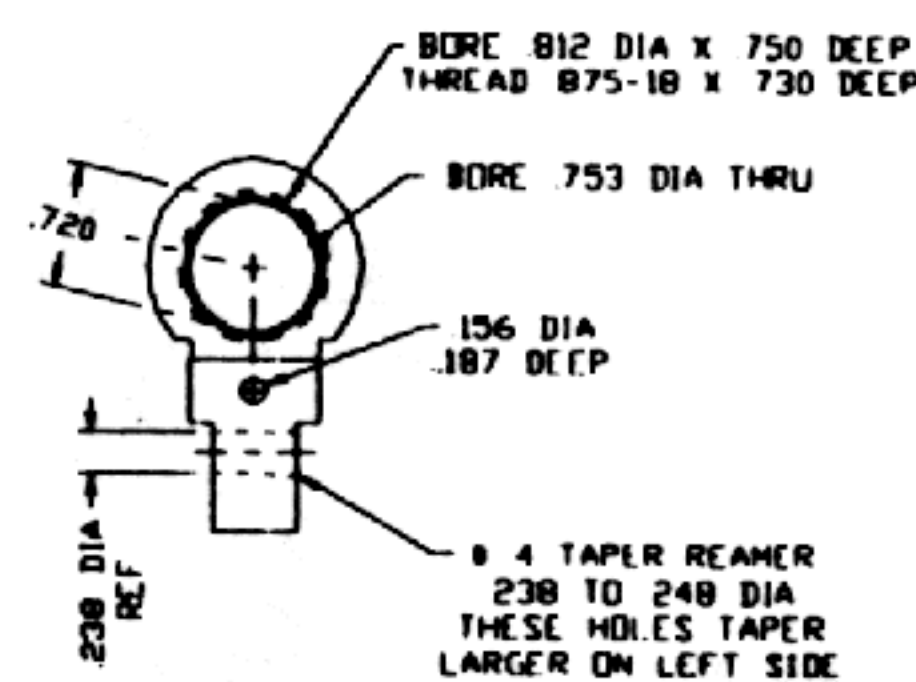
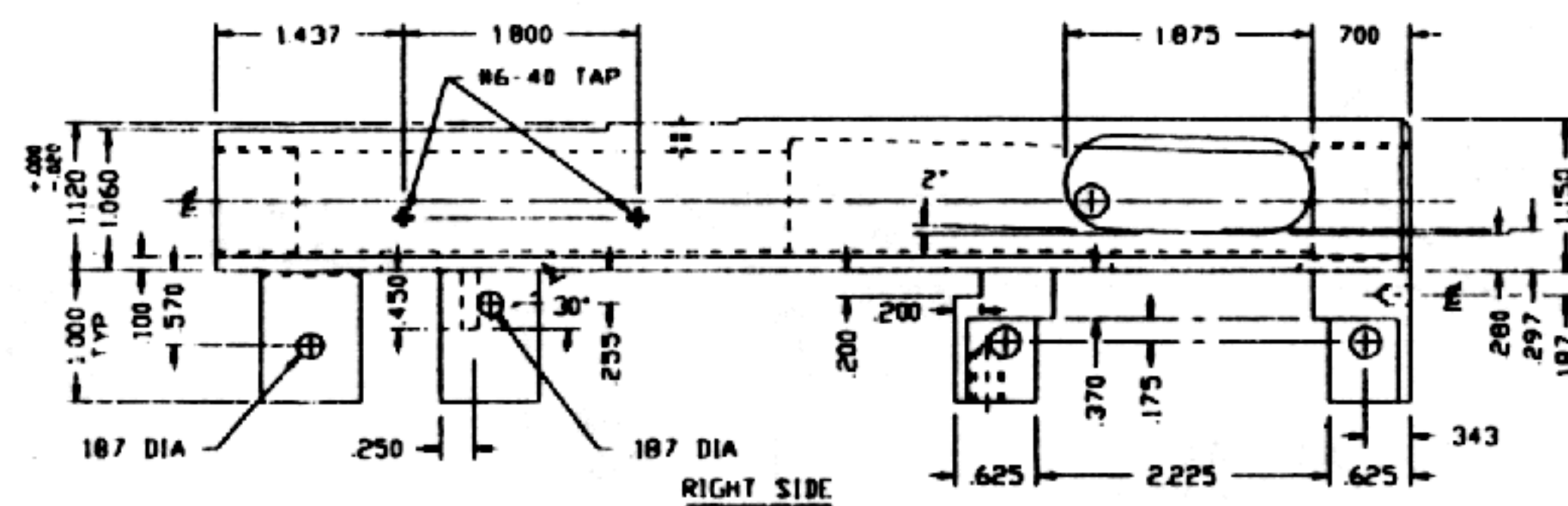
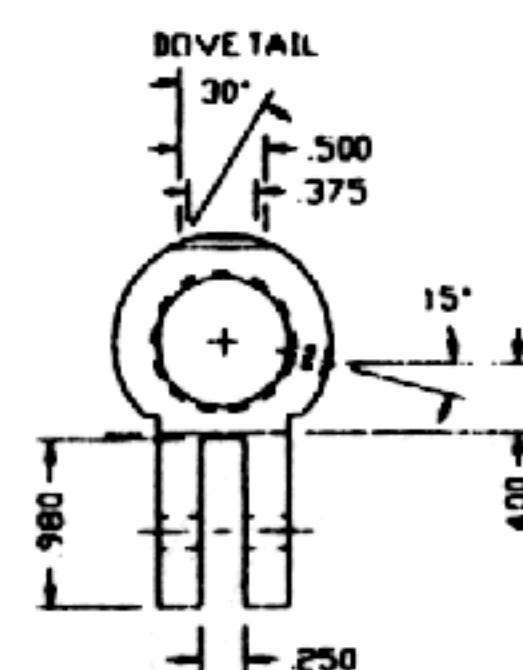
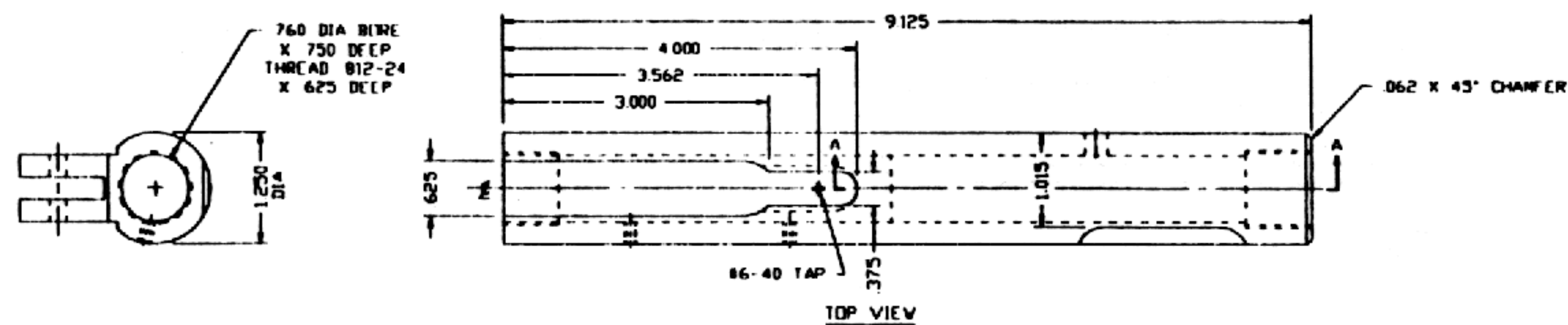
1. MATERIAL- 1625 O.D. X 1.312 I.D. DDM STEEL TUBE
2. FINISH- PAKERIZE THEN PAINT BLACK OR CAMOFLAGE
3. SOME PART KITS COME WITH FRONT RECEIVER PARTS IN TACT. IF THIS IS YOUR CASE, THEN REAR PART OF RECEIVER TUBE CAN BE ALIGNED AND BUTT WELDED.
4. IF PARTS ARE LOOSE, REFER TO 'VIEW B' FOR THEIR LOCATION
5. Ø 5/16-22 THREAD IS BRITISH AND CAN BE SUBSTITUTED WITH Ø 7 DRILL (.201 DIA) AND TAP Ø 1/4-20 THREAD. REPLACE ORIGINAL Ø 5/16 SCREW WITH Ø 1/4-20 ROUND HEAD SCREW
6. SPRING RETAINER IS 1.312 O.D. WITH .562 DIA HOLE IN CENTER AND .500 WIDE. WELD IN PLACE USING 3 OR 4 DRILLED HOLES EQUALLY SPACED IN RECEIVER TUBE AT 3.875 DIMENSION AFTER ARC WELDING SPRING RETAINER AND RECEIVER TUBE TOGETHER DRILL AND TAP Ø 1/4-20 HOLE IN BOTTOM FOR TRIGGER FRAME HOLD DOWN SCREW.
7. WHEN 3" TAPER IS CUT ON REAR OF RECEIVER TUBE IT SHOULD MEASURE 1.400 AT SMALL END. MUST COVER FITS IN PLACE OVER THIS TAPER.
8. EARLY MODEL BARRELS WERE FINISHED. LATE MODEL BARRELS WERE PLAIN.

**RESTRICTED  
MATERIAL**

**CONFIDENTIAL**

SCALE	FULL	MATERIAL	SEE NOTE 1	CBS	TOLERANCES
DWG		FINISH	SEE NOTE 2	DATE	DEC 2 PL 1/2
TITLE	OVEN MK II MODEL 1943 RECEIVER			REV.	DEC 2 PL 1/2
					ANGLES ± .01





**CONFIDENTIAL**

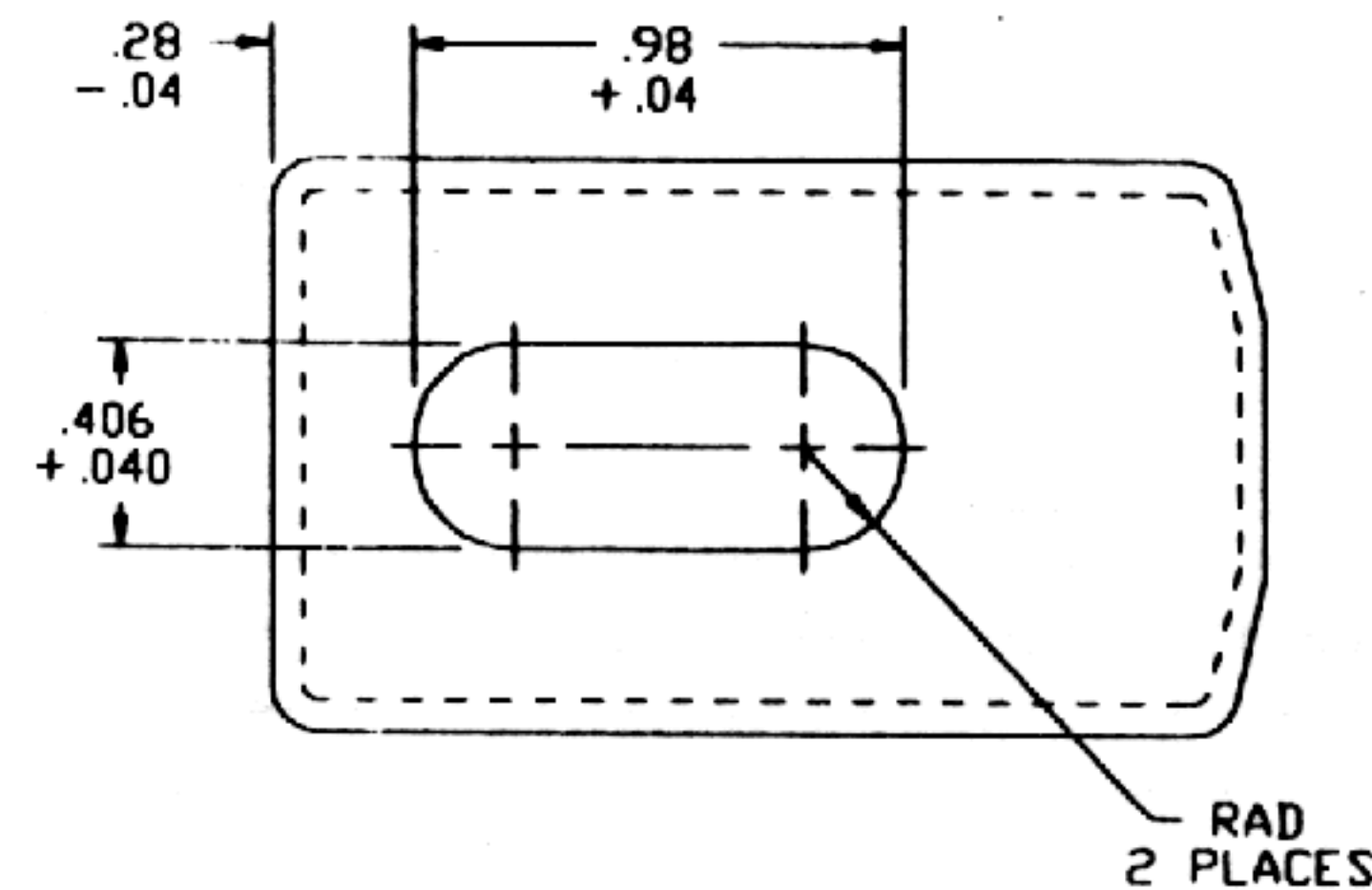
**NOTES:**

1. MATERIAL - 1020 STEEL DOM TUBING
2. FINISH - MILITARY 30 PARKERIZE, CIVILIAN 30 OR 60 BLUE
3. DARKENED AREAS AROUND 750 DIA POST REPRESENT ELECTRIC WELDS AFTER POSTS HAVE BEEN BRAZED OR SILVER BRAZED IN PLACE JUST LIKE ORIGINAL RECEIVER
4. 375 AREA OF SIGHT SLOT IS UNDERCUT WITH A 60° DOVETAIL CUTTER
5. EJECTION PORT IS ANGLED TO RESULT IN .280 DIMENSION IN FRONT AND 297 IN REAR
6. BORE OR REAM 753 DIA THRU HOLE BEFORE CUTTING OFF SET
7. SEMI AUTOMATIC RECEIVER CAN BE ACCOMPLISHED BY NOT CUTTING 125 SLOT WITH 30° RAMP AND .125 HOLE X .450 DEEP THIS WILL NOT ALLOW DISCONNECTOR TO BE ASSEMBLED

**RESTRICTED  
MATERIAL**

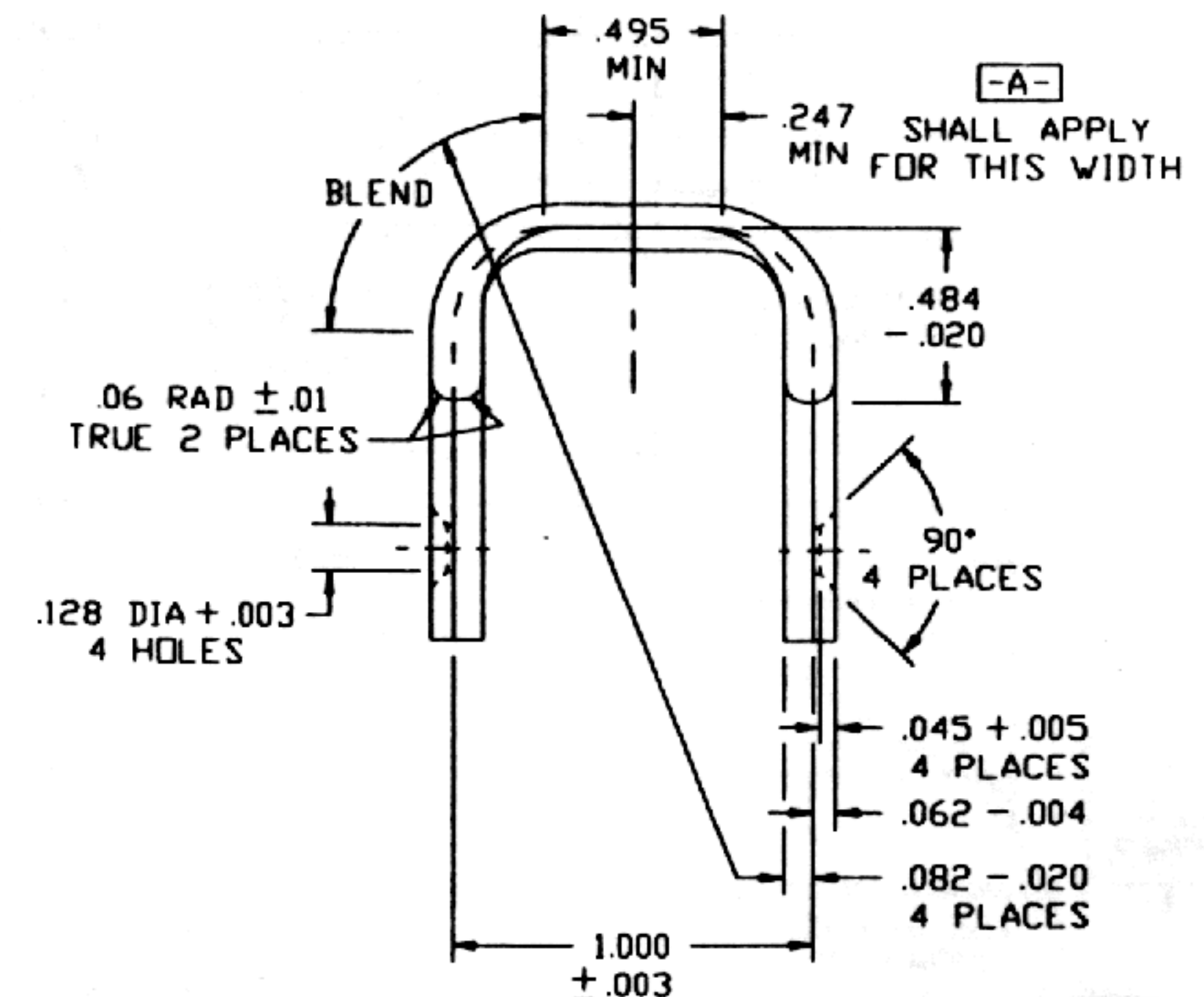
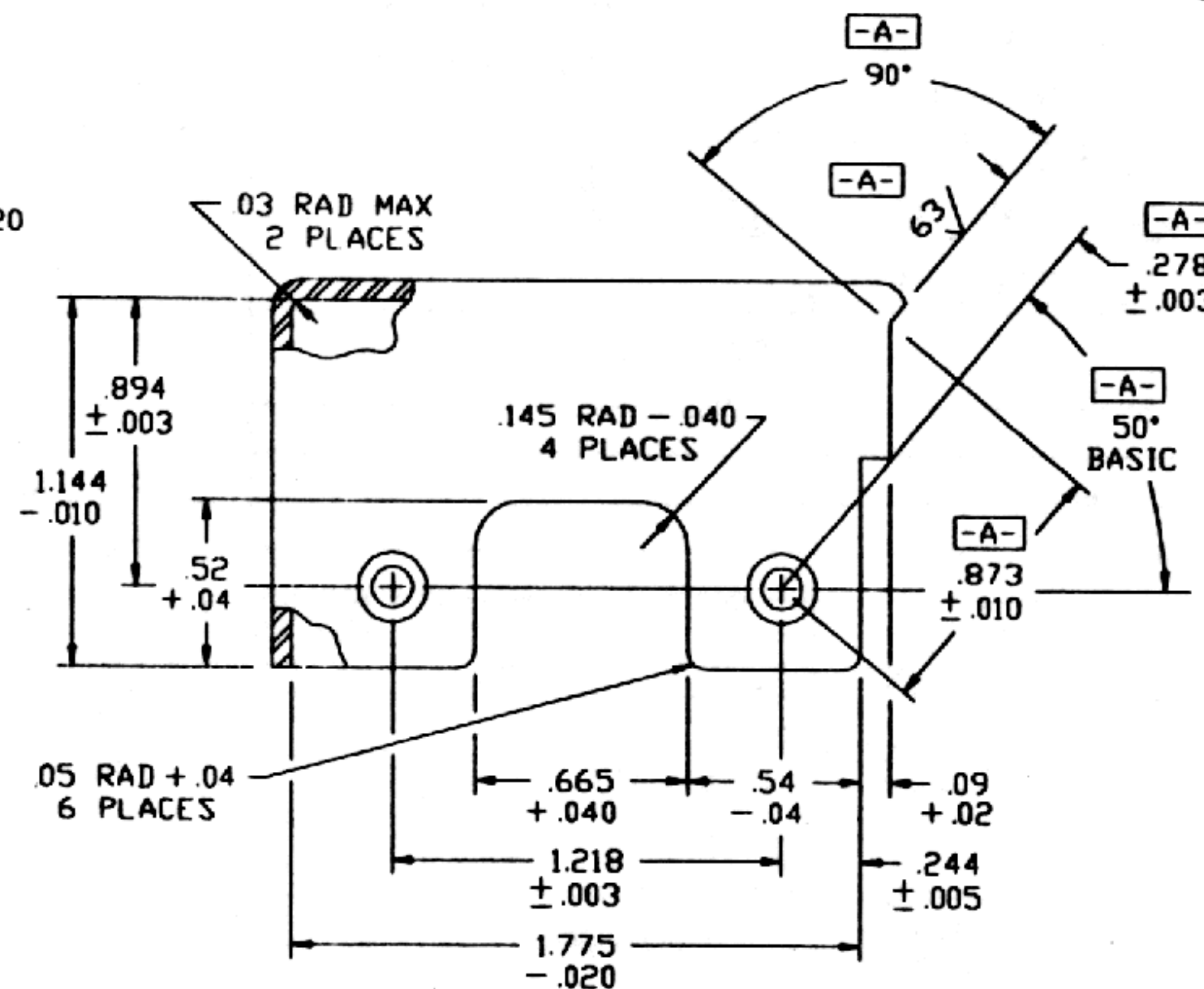
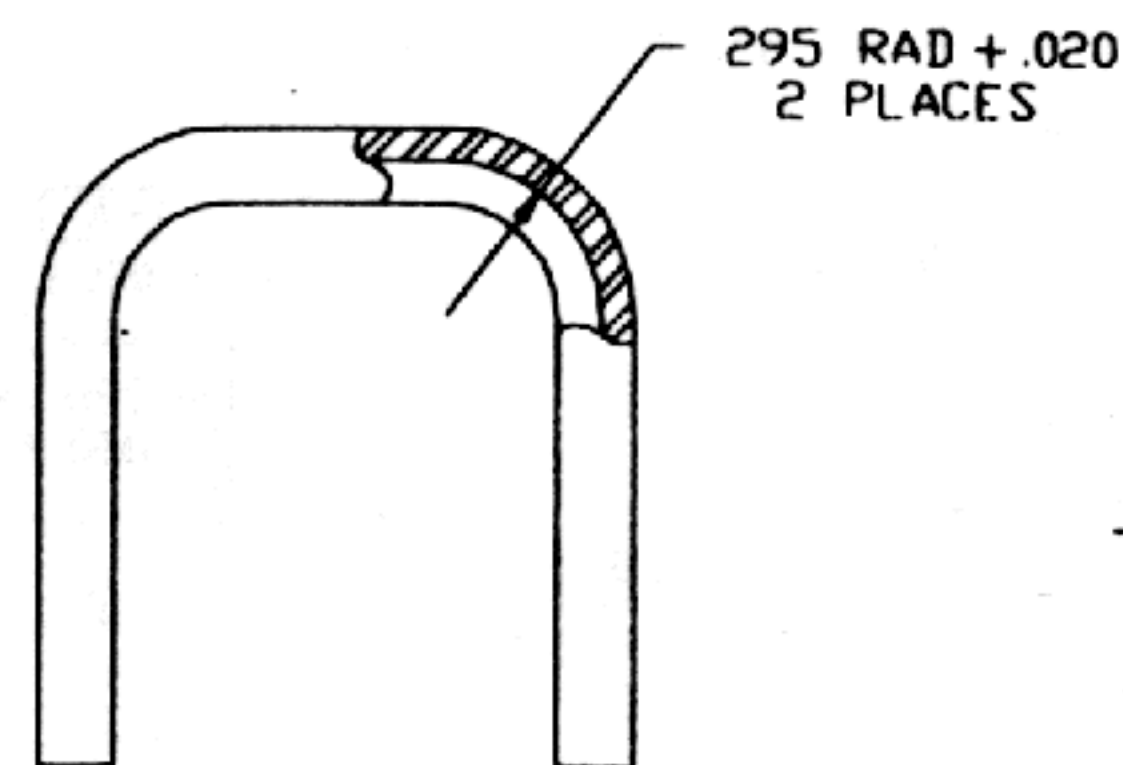
SCALE	FULL	MATERIAL	SEE NOTE 1	DES		TOLERANCES
FIN		FINISH	SEE NOTE 2	DATE		REC'D: 51
TITLE	REISING RECEIVER			REV.		REC'D: 80
						INCHES: .001





# NOTES:

1. FINISH  $\sqrt{125}$  EXCEPT AS NOTED. SHEARED SURFACES  $\sqrt{250}$ .
2. ALL EDGES SHALL BE BROKEN .005 + .010 UNLESS OTHERWISE SPECIFIED.
3. MATERIAL - STEEL QQ-S-698 CARBON .17 TO .24, MANGANESE .30 TO .60 DRAWING QUALITY KILLED.
4. HEAT TREATMENT - CARBURIZE AT 1600°F FOR .005 TO .010 CASE DEPTH. OIL QUENCH. TEMPER 30 MINUTES AT 350°F. HEAT TREATMENT METHOD IS FOR GUIDANCE, EXCEPT THAT CASE DEPTH AND HARDNESS REQUIREMENT ARE MANDATORY AND TIME AT TEMPERATURE SHALL NOT BE REDUCED BELOW THAT SPECIFIED. THE USE OF STRAIGHT CYANIDE BATH OR CARBONITRIDING PROCESS SHALL NOT BE PERMITTED WITHOUT PRIOR APPROVAL OF THE CONTRACTING OFFICER.
5. FILEHARD TEST IN ACCORDANCE WITH SA-STD-104. (H1)
6. FINAL PROTECTIVE FINISH 5.3.1.2 OF MIL-STD-171



RESTRICTED  
MATERIAL

CONFIDENTIAL

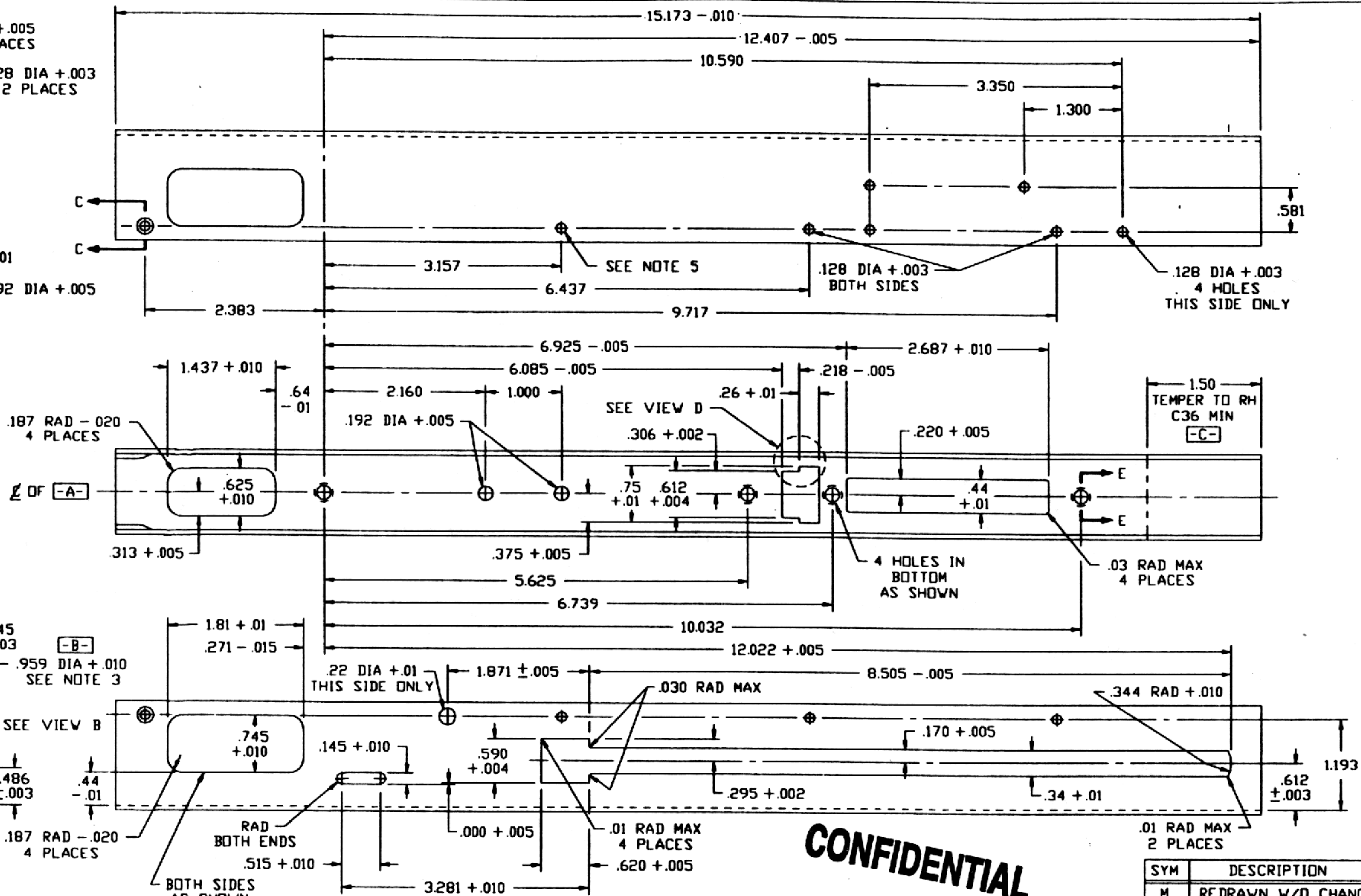
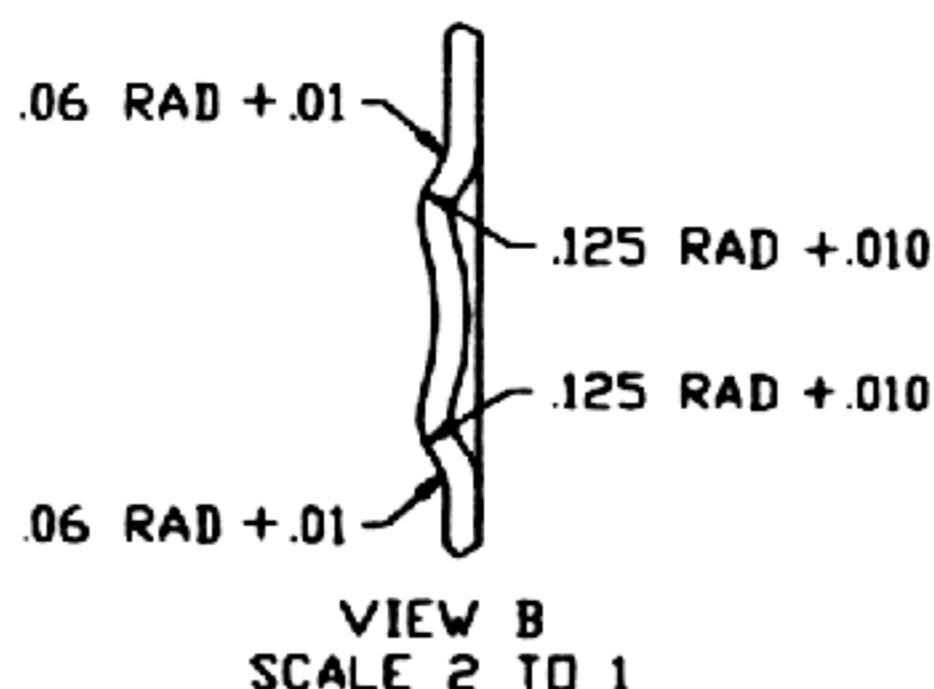
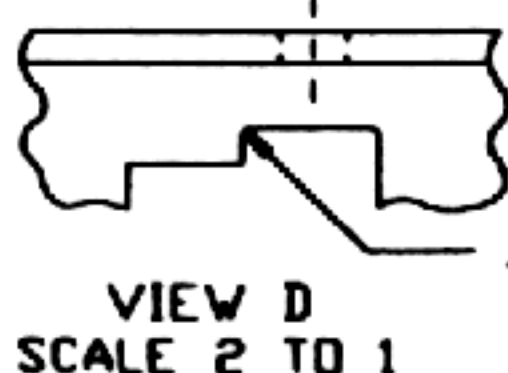
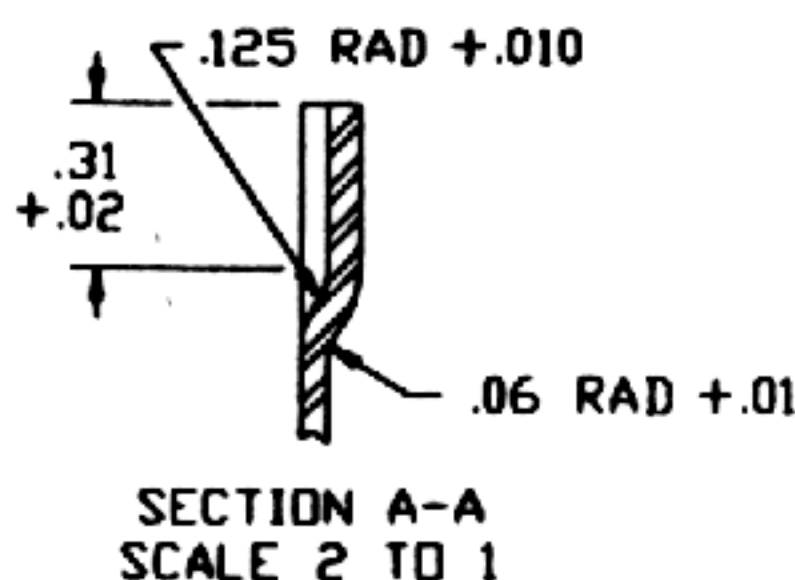
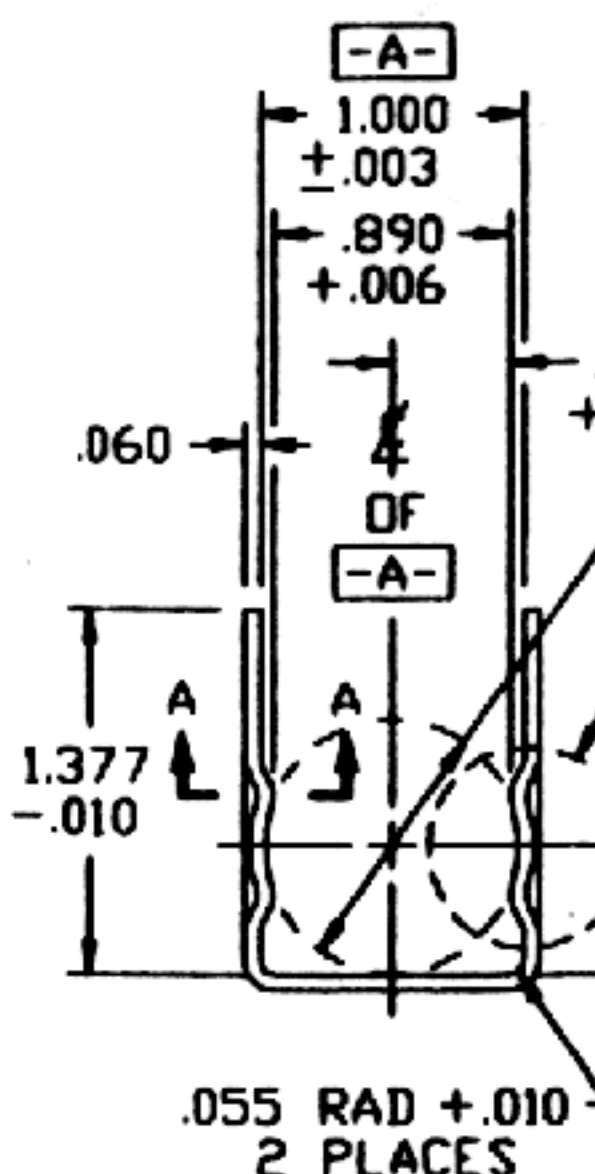
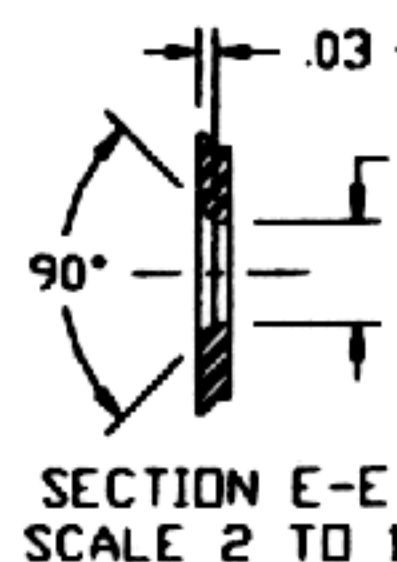
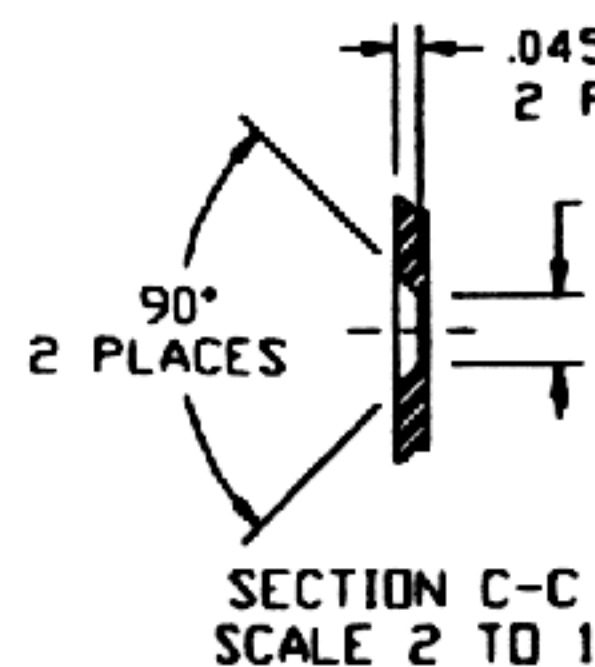
NEXT ASSEMBLY	F11686308	MG, 7.62 MM - M60, M60C.
	F11699805	M60D

CODE IDENT NO. 19205  
DRAWN FROM ORD PART NO. 7269252  
SPRINGFIELD ARMORY ORDNANCE CORPS  
DEPT OF THE ARMY  
SPRINGFIELD 1, MASS

SYM	DESCRIPTION
G	REDRAWN WITH CHANGE SEE EO NO. SA30116
H	(1) SEE EO HRD 82232

SCALE: 2 TO 1	MATERIAL: SEE NOTE 3	CKD.	TOLERANCES
DWN.	FINISH: SEE NOTE 1	DATE	DEC 2 PL ± .02 H H 2 PL ± .51
TITLE: M60 BRIDGE, RECEIVER	REV.		DEC 3 PL ± .005 H H 3 PL ± .127 ANGLES ± .5°
			NO





**CONFIDENTIAL**

- NOTES:
1. FINISH  $125\sqrt{\text{ }}$  EXCEPT SHEARED EDGES  $250\sqrt{\text{ }}$ .
  2. ALL EDGES SHALL BE BROKEN  $.005 +.010$  UNLESS OTHERWISE SPECIFIED.
  3. **-B-** APPLIES WHEN **-A-** IS MAINTAINED AT 1.00 DATUM.
  4. HEAT TREATMENT- HEAT AT  $1500^{\circ}$  TO  $1535^{\circ}$ F. OIL QUENCH. TEMPER ONE HOUR TO HARDNESS SPECIFIED HEAT TREATMENT METHOD IS FOR GUIDANCE EXCEPT THAT TEMPERING TIME SHALL NOT BE REDUCED BELOW THAT SPECIFIED. TOTAL AND PARTIAL DECARBURIZATION PERMISSIBLE TO  $.002$  MAX.
  5. SEE RECEIVER ASSEMBLY DWG F11686308 AND F11699805 FOR DIA OF HOLE. EACH SIDE.
  6. FINISH- 5.3.1.2 OF MIL-STD-171. EXCEPT PARA 3.3 OF MIL-P-16232 SHALL NOT APPLY.
  7. MATERIAL- STEEL QQ-S-777 1060, 1065, 1075.

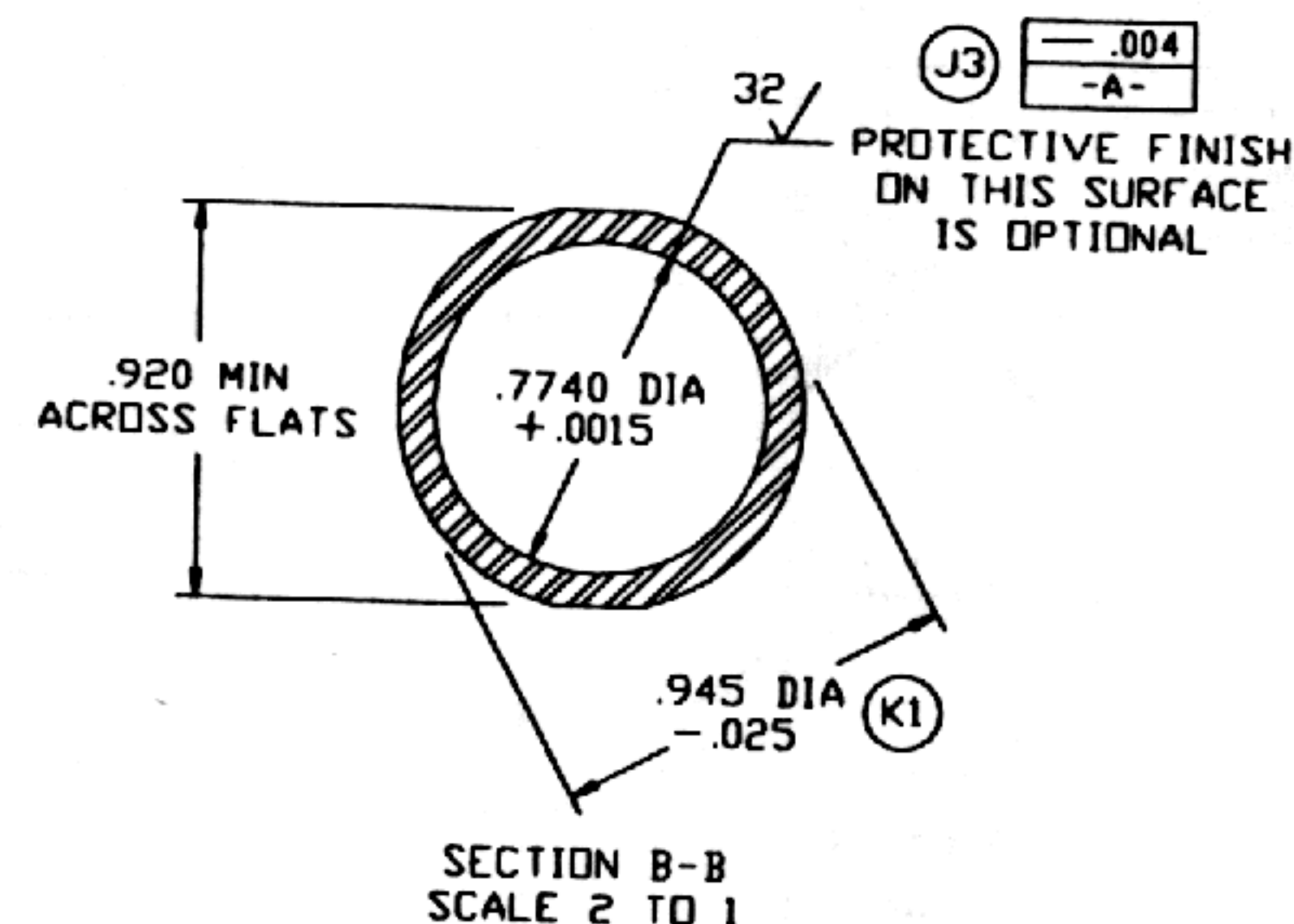
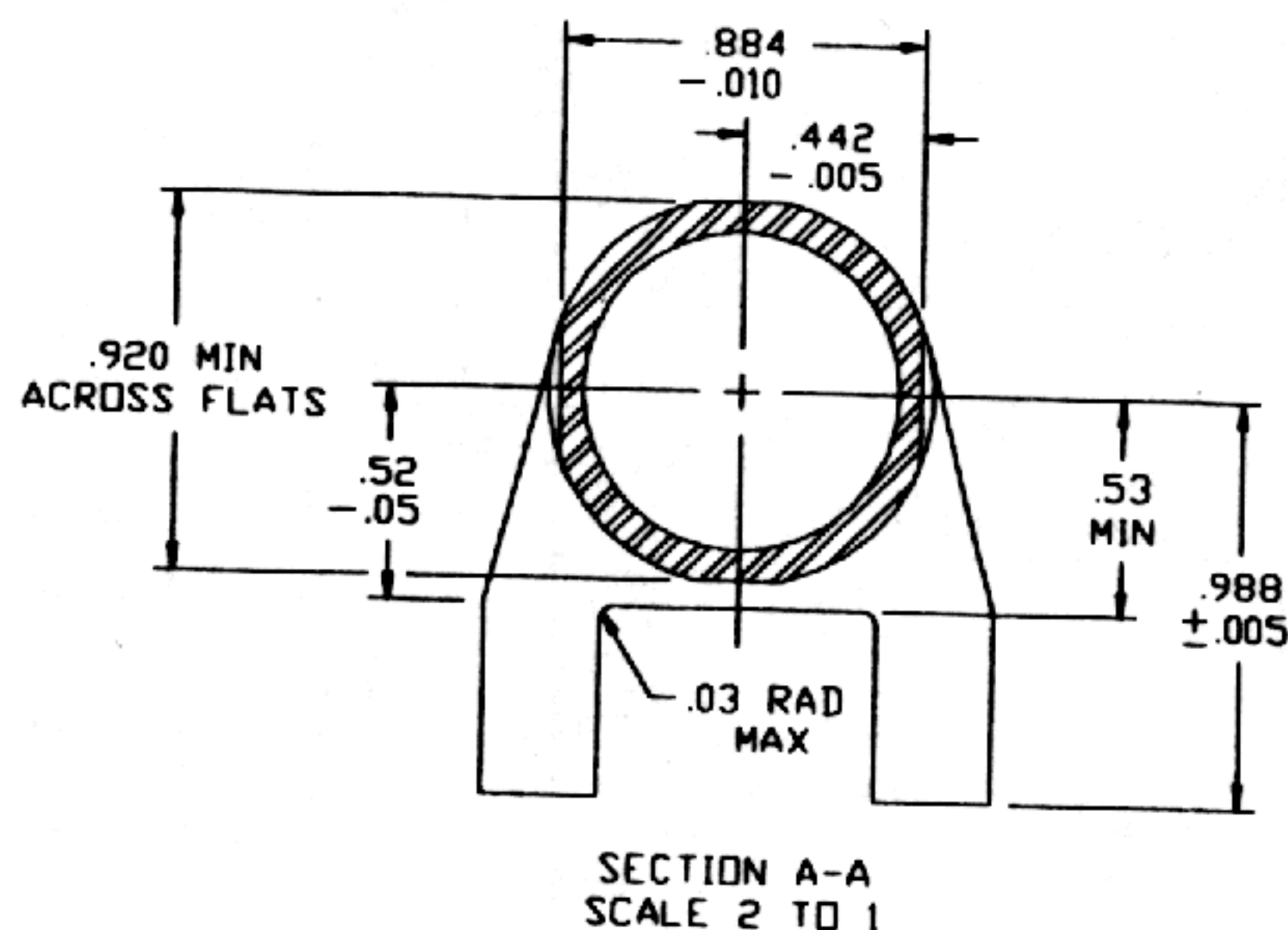
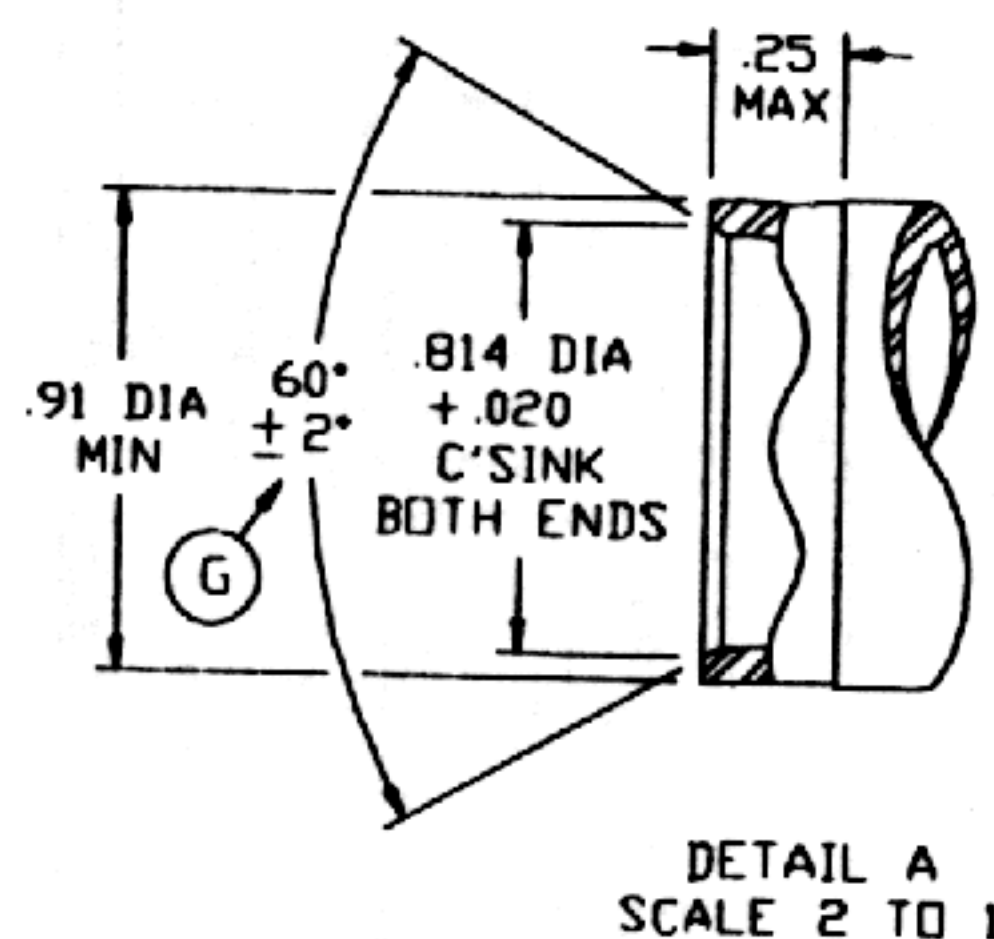
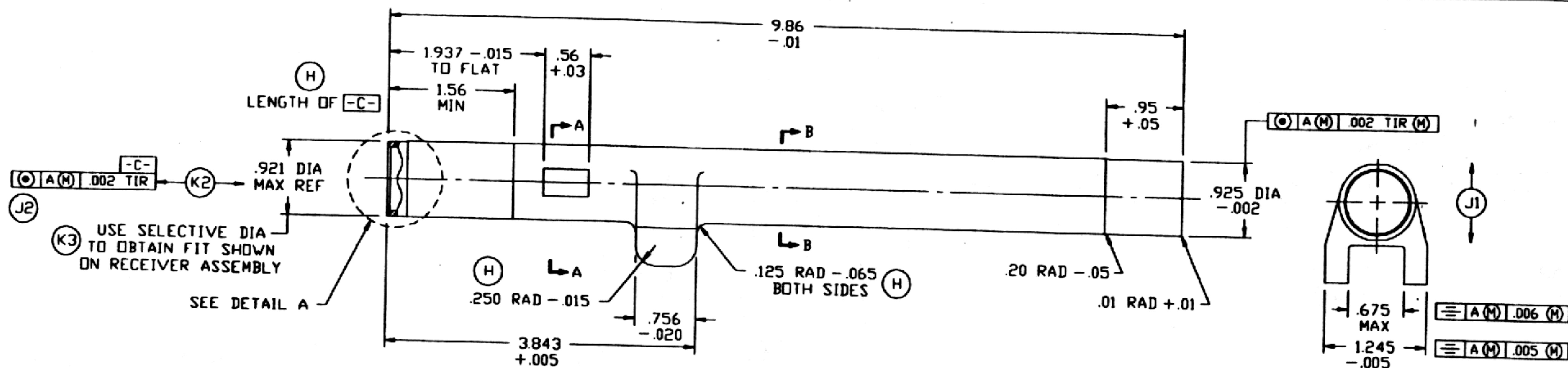
SYM	DESCRIPTION
M	REDRAWN W/D CHANGE SEE EO NO. SA30121
N	(1-2) SEE EO HRD 82232

NEXT ASSEMBLY	F11686308	MG, 7.62 MM M60	(P2)
	F11699805	M60D	

CODE IDENT NO. 19205  
 DRAWN FROM ORD PART NO. 7269254  
 SPRINGFIELD ARMORY ORDNANCE CORPS  
 DEPT OF THE ARMY  
 SPRINGFIELD 1, MASS

SCALE: FULL	MATERIAL: SEE NOTE 7	CKD.	TOLERANCES
DWN.	FINISH: SEE NOTE 1	DATE	DEC 2 PL $\pm .02$
TITLE: M60 CHANNEL, RECEIVER	REV.		DEC 3 PL $\pm .005$
			ANGLES $\pm 5^{\circ}$





#### NOTES:

1. FINISH  $125\sqrt{\text{EXCEPT AS NOTED. FORGED SURFACES } 250\sqrt{\text{J5}}$
2. MATERIAL- STEEL, COMP 4140, SPEC QQ-S-624 (J5) OR COMP 1141, SPEC QQ-S-637, EXCEPT HOT FINISHED 1141 STEEL BARS FOR FORGING PURPOSES, AND ALL OTHER CONDITIONS OF SPECIFICATIONS ARE COMPLIED WITH. (L1)
3. HEAT TREATMENT- HEAT AT 1525° TO 1575°F. OIL QUENCH. TEMPER 1 HOUR AT HEAT TO HARDNESS SPECIFIED. HEAT TREATMENT METHOD IS FOR GUIDANCE EXCEPT THAT TEMPERING TIME SHALL NOT BE REDUCED BELOW THAT SPECIFIED.
4. FINAL PROTECTIVE FINISH 5.3.1.2 OF MIL-STD-171

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**RESTRICTED MATERIAL**

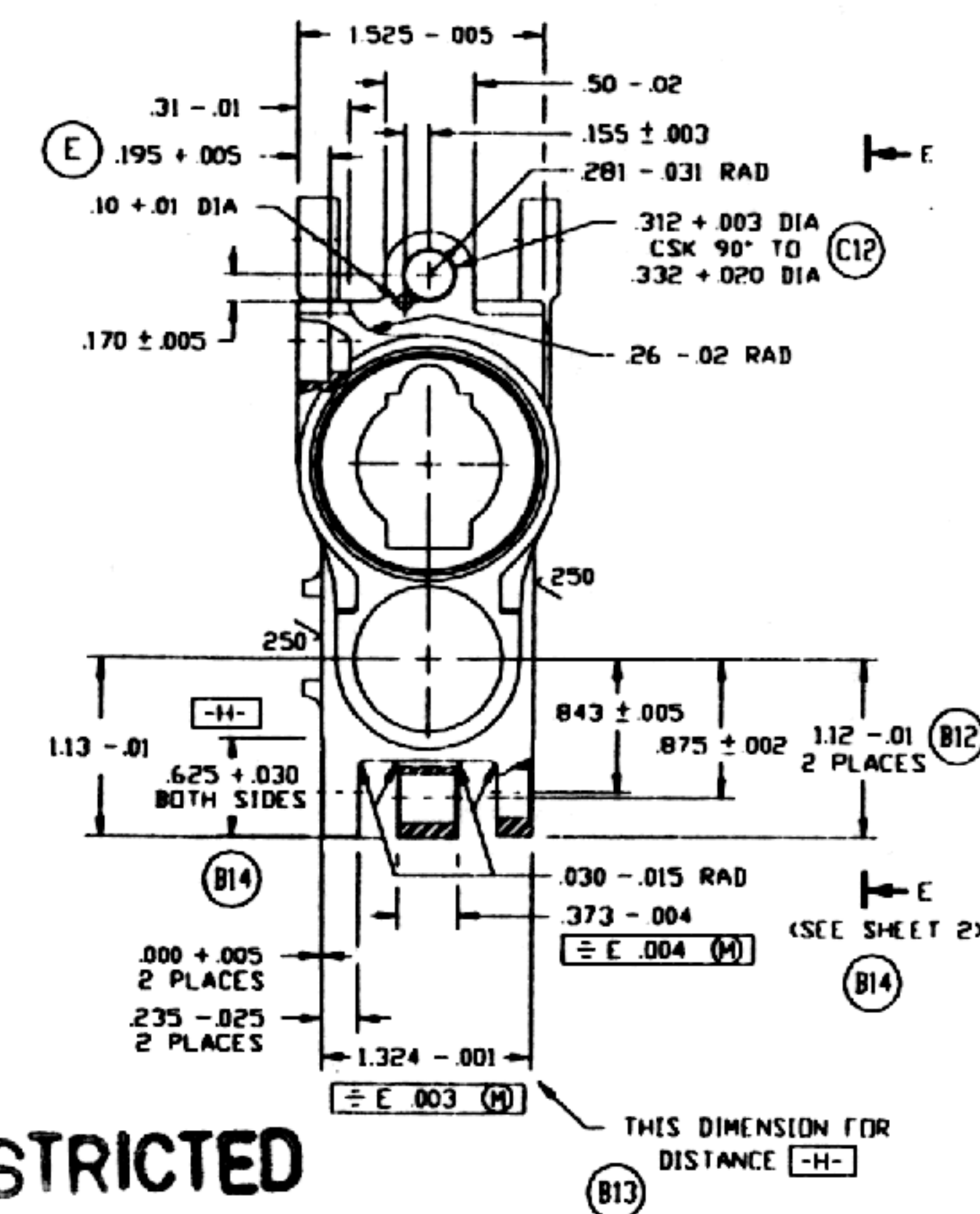
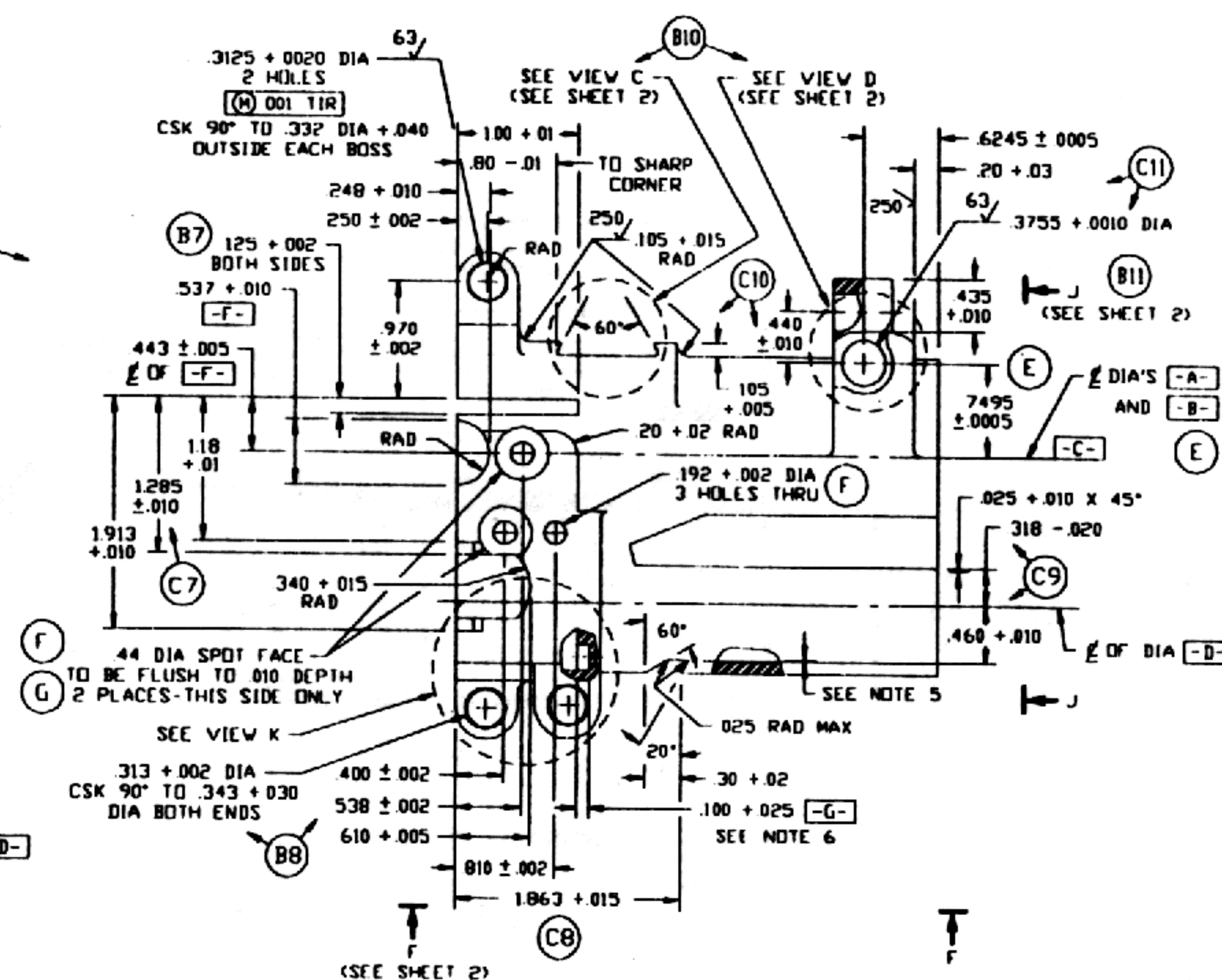
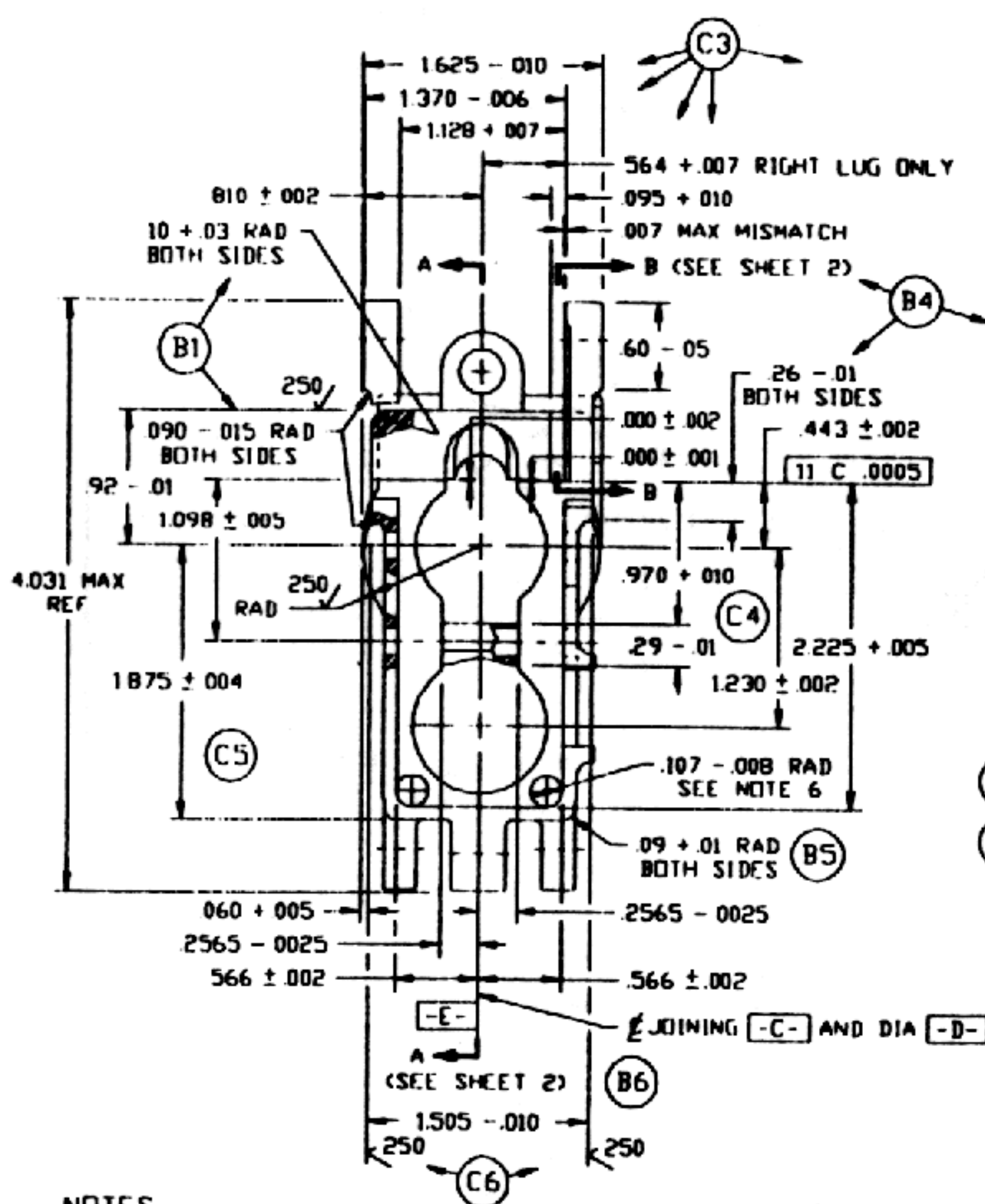
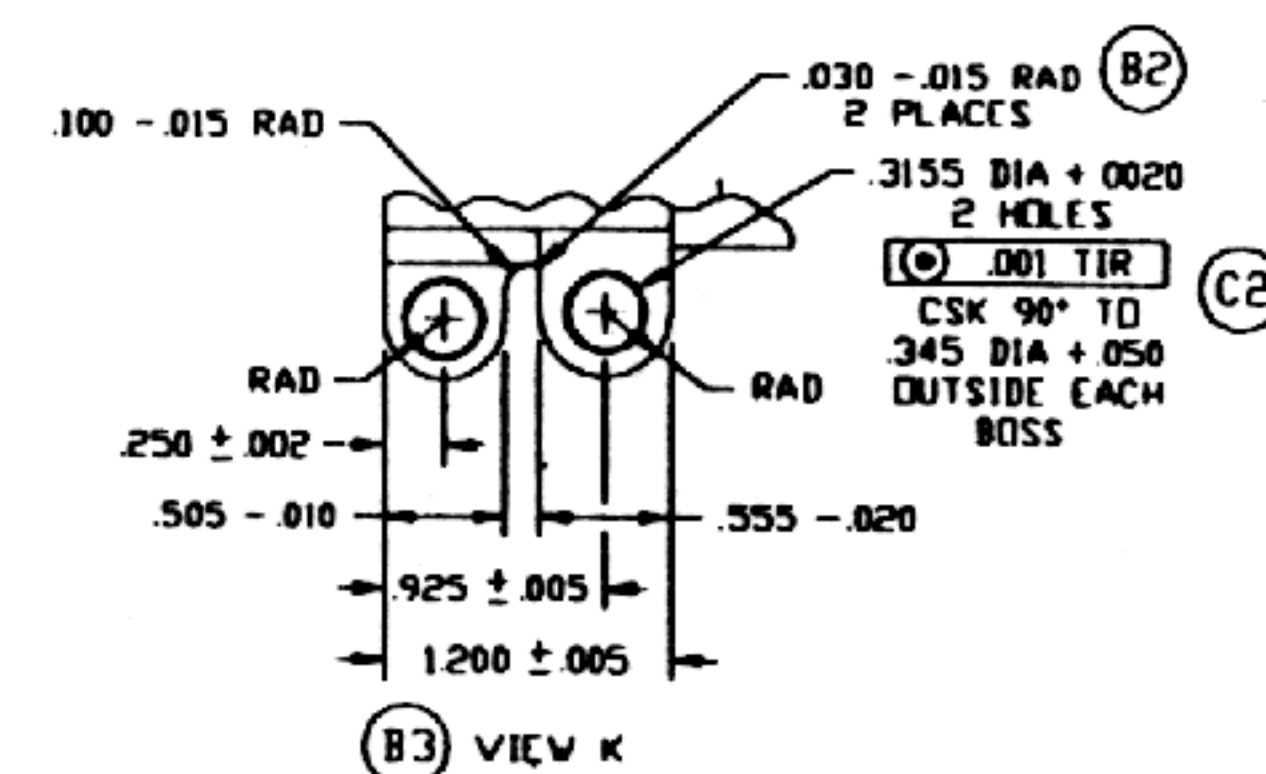
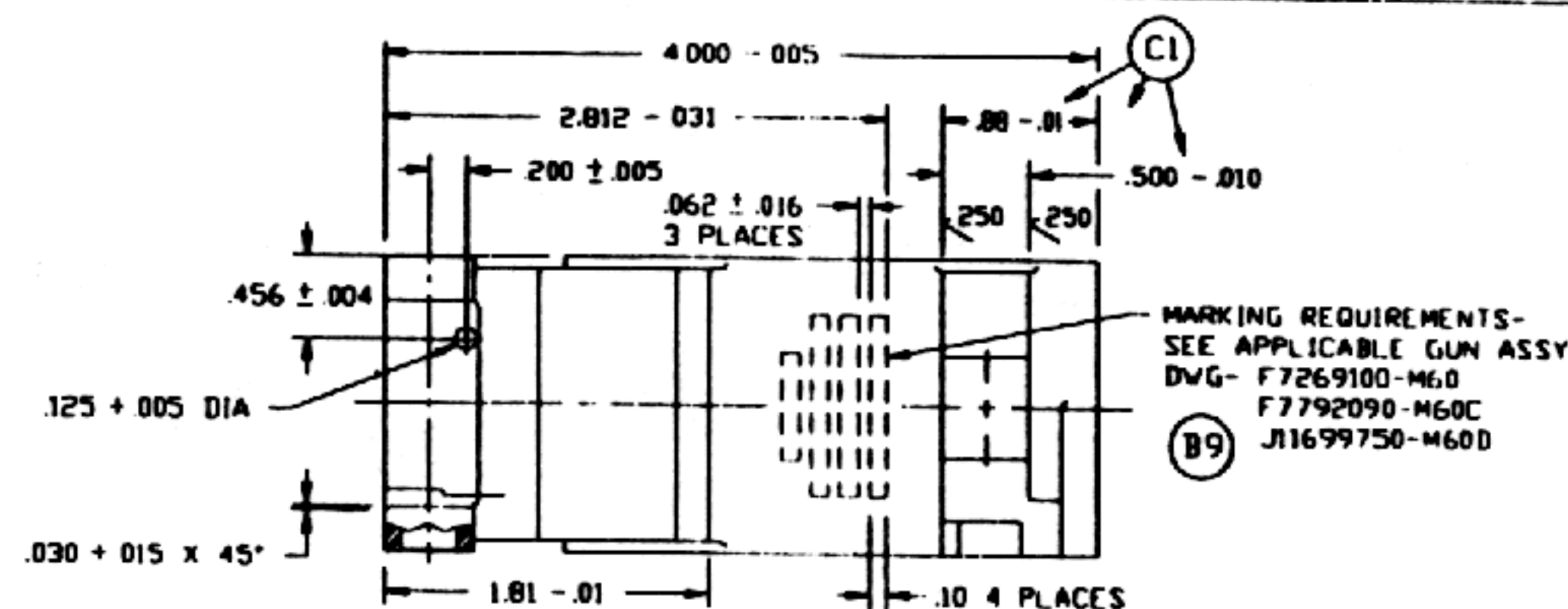
SYM	DESCRIPTION
E	
F	REDRAWN & REVISED SEE ED SA26085
G2	REF ED NO. SA27115
H5	REF ED NO. SA27297
J	(1-5) REF ED SA28042
K	(1-3) SEE ED SA29002
L	(1) SEE ED HRD 82370

NEXT ASSEMBLY	F11686308	MG, 7.62 MM - M60, M60C.
	F11699805	M60C

CODE IDENT NO. 19205  
DRAWN FROM ORD PART NO. 7269256 (H)  
SPRINGFIELD ARMORY ORDNANCE CORPS  
DEPT OF THE ARMY  
SPRINGFIELD 1, MASS

SCALE: FULL	MATERIAL: SEE NOTE 2	CKD.	TOLERANCES
DWN.	FINISH: SEE NOTE 1	DATE	DEC 2 PL $\pm .02$
TITLE: M60 GUIDE, OPERATING ROD	REV.		DEC 3 PL $\pm .05$
			DEC 3 PL $\pm .127$
			ANGLES $\pm 5^\circ$
			NO.





# NOTES:

1. FINISH 125/ EXCEPT AS NOTED.
2. ALL EDGES SHALL BE BROKEN .005 ± .010 UNLESS OTHERWISE SPECIFIED.
3. ALL UNSPECIFIED RADII SHALL BE .030 ± .030.
4. HEAT TREATMENT- HEAT AT 1535° TO 1565° F. OIL QUENCH. TEMPER ONE HOUR TO HARDNESS SPECIFIED. HEAT TREATMENT METHOD IS FOR GUIDANCE EXCEPT THAT TEMPERING TIME SHALL NOT BE REDUCED BELOW THAT SPECIFIED.
5. BREAK THRU SHALL BE PERMISSIBLE IN THIS AREA PROVIDED RESULTANT BURRS ARE REMOVED.
6. .215 DIA ± .015 (2) HOLES MAY BE MACHINED IN CORNERS FOR DEPTH -G- TO PROVIDE REQUIRED RADIUS.
7. FINISH 5.3.12 OF MIL-STD-171. (G)
8. ALL RIVET HOLES AND THEIR C'SINKS MAY BE OMITTED (D) OR LEFT UNDERSIZE PROVIDED THEY ARE PUT IN AT ASSEMBLY TO THE DIMENSIONAL REQUIREMENTS AT THE COMPONENT LEVEL.
9. MIL-W-13855 APPLIES. (E)
10. MATERIAL- STEEL QQ-S-624 4140, .0640, .0740.

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**RESTRICTED MATERIAL**

NEXT ASSEMBLY	F11686308	MG, 7.62 MM - M60, M60C
	F11699805	M60D

CODE IDENT NO. 19204  
DRAWN FROM ORD PART NO. 11686307 SHEET 1 OF 2  
ROCK ISLAND ARSENAL  
DEPT OF THE ARMY  
ROCK ISLAND, ILL.

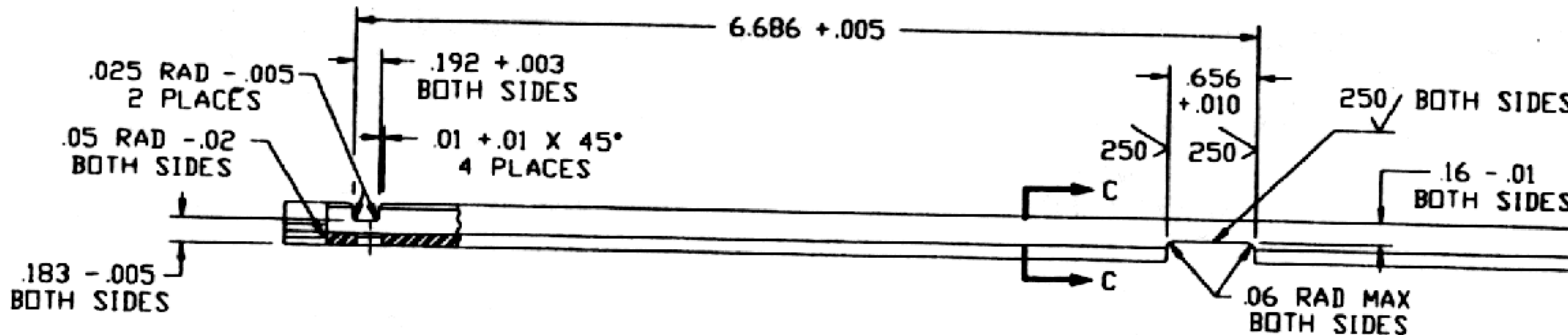
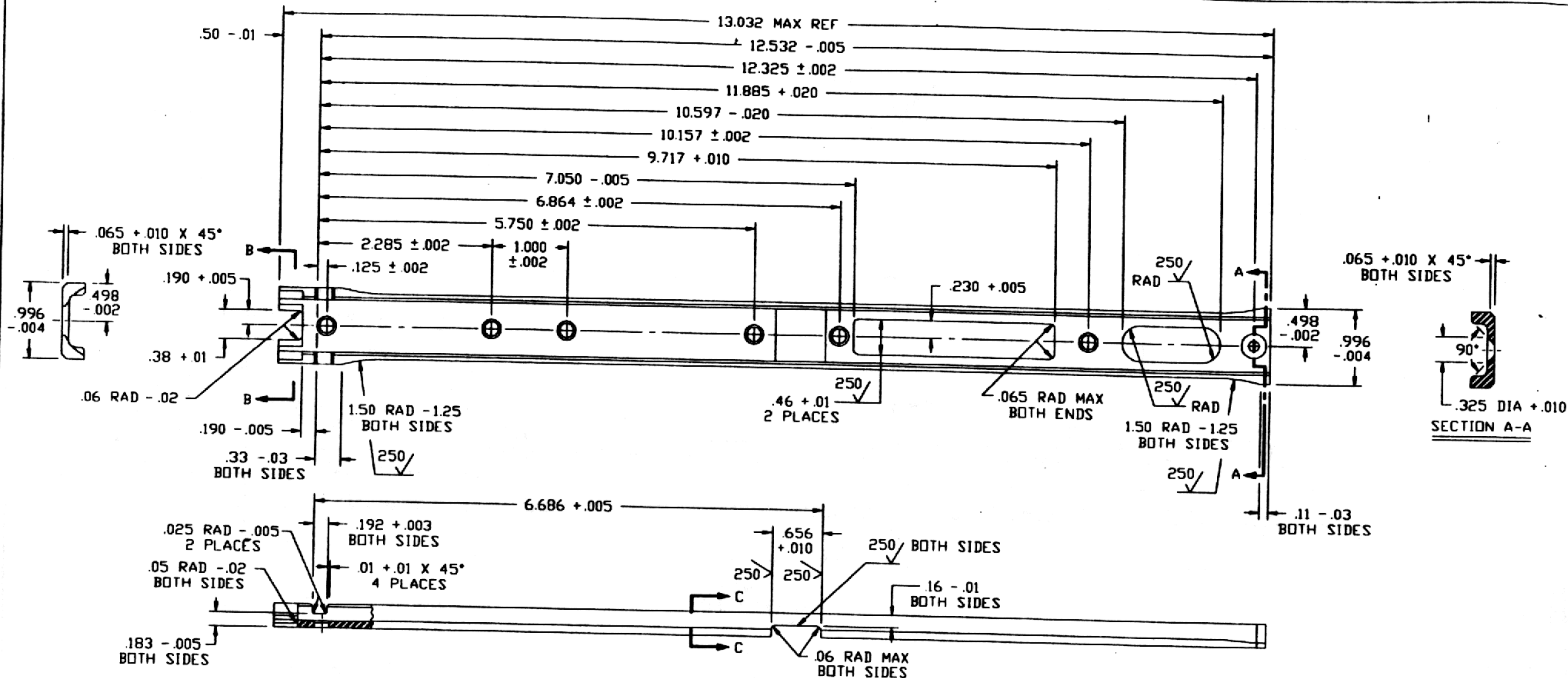
SYM	DESCRIPTION
A	SEE ED SA29002
B	(1-14) SEE ED SA30032
C	(1-15) SEE ED 82128
D	(1-2) SEE ED HRD 82232
E	(1-4) SEE ERR HDR 10724
F	(2) SEE ERR HDR 30781
G	(2) SEE HDR 75E0036-0002

SCALE: FULL	MATERIAL: SEE NOTE 10	CKD.	TOLERANCES
DWN.	FINISH: SEE NOTE 1	DATE	DEC 2 PL ± .02
TITLE: M60 RECEIVER	REV.		DEC 3 PL ± .005
			ANGLES ± .5°

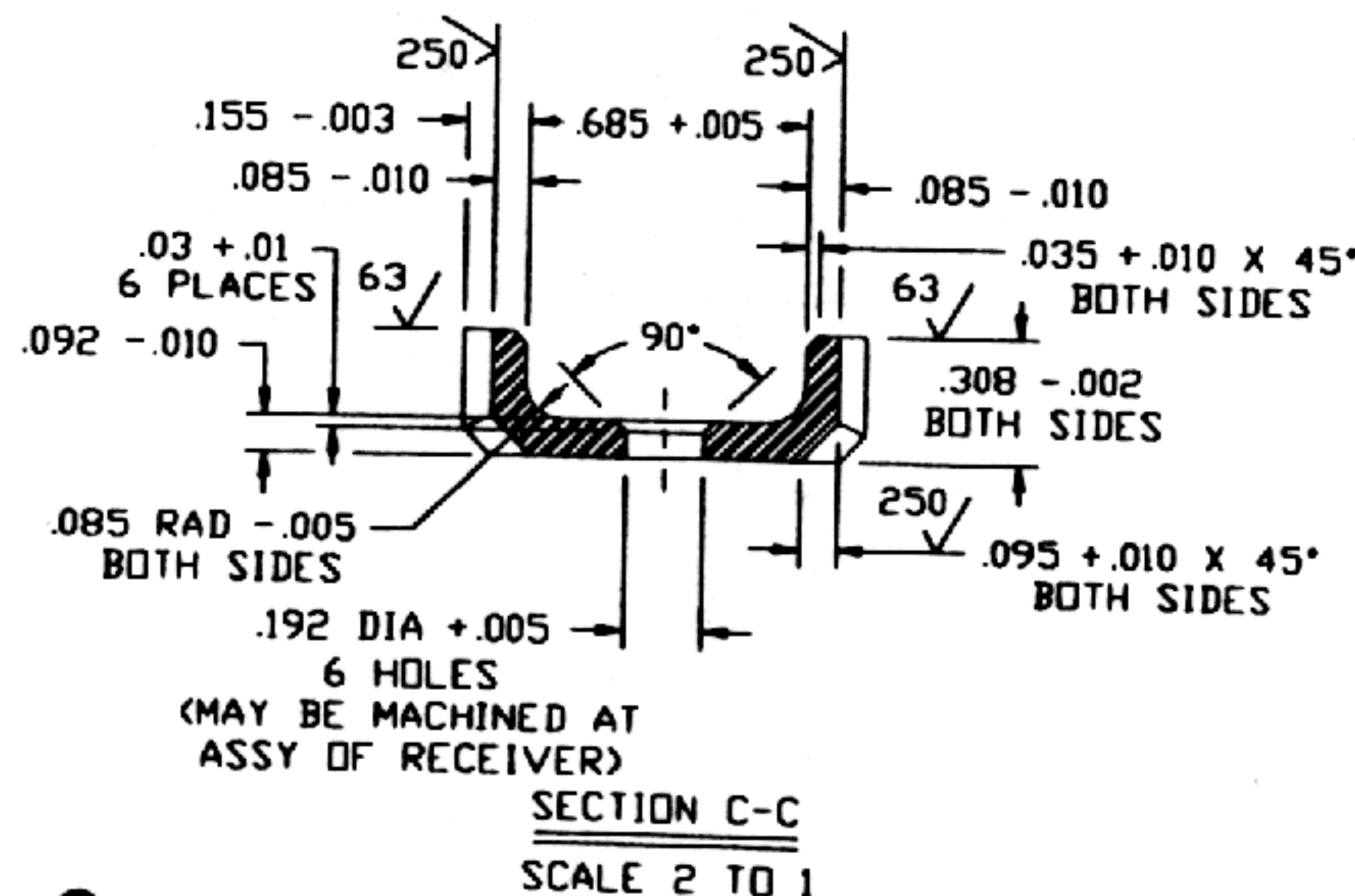








SECTION B-B  
ROTATED 90° CW  
SCALE 2 TO 1



SECTION C-C  
SCALE 2 TO 1

RESTRICTED  
MATERIAL

- NOTES:
- 1 FINISH 125/ EXCEPT AS NOTED.
  2. ALL EDGES SHALL BE BROKEN .005 ± .010 UNLESS OTHERWISE SPECIFIED.
  3. HEAT TREATMENT- HEAT AT 1535° TO 1565° F. OIL QUENCH. TEMPER ONE HOUR TO HARDNESS SPECIFIED. HEAT TREATMENT METHOD IS FOR GUIDANCE EXCEPT THAT TEMPERING TIME SHALL NOT BE REDUCED BELOW THAT SPECIFIED.
  4. HEAT TREAT BEFORE MACHINING.
  5. ALL RIVET HOLES AND THEIR C'SINKS MAY BE OMITTED OR LEFT UNDERSIZE PROVIDED THEY ARE PUT IN AT ASSEMBLY TO THE DIMENSIONAL REQUIREMENTS AT THE COMPONENT LEVEL. (L1)
  6. MATERIAL- STEEL QQ-S-624 4140, 8640, 8740.

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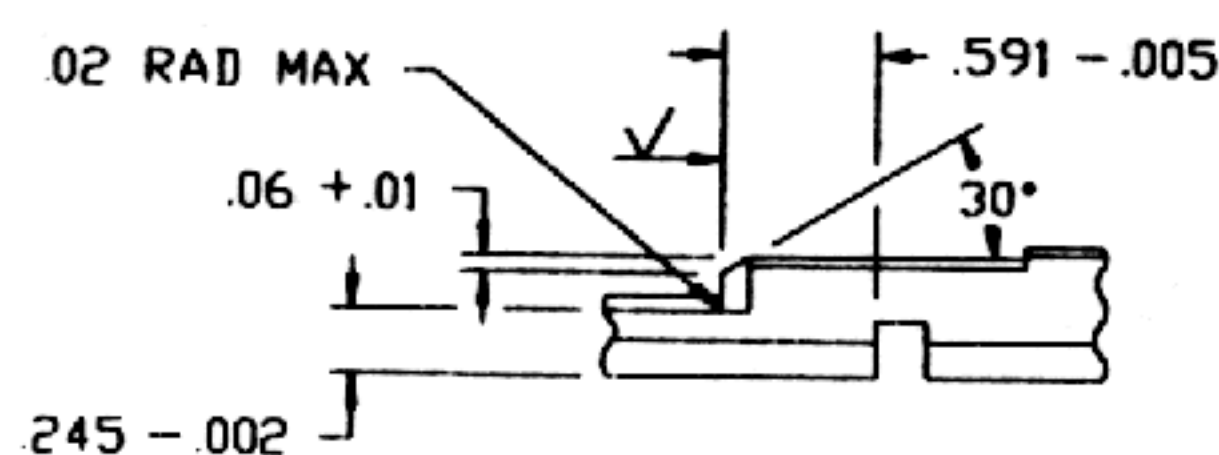
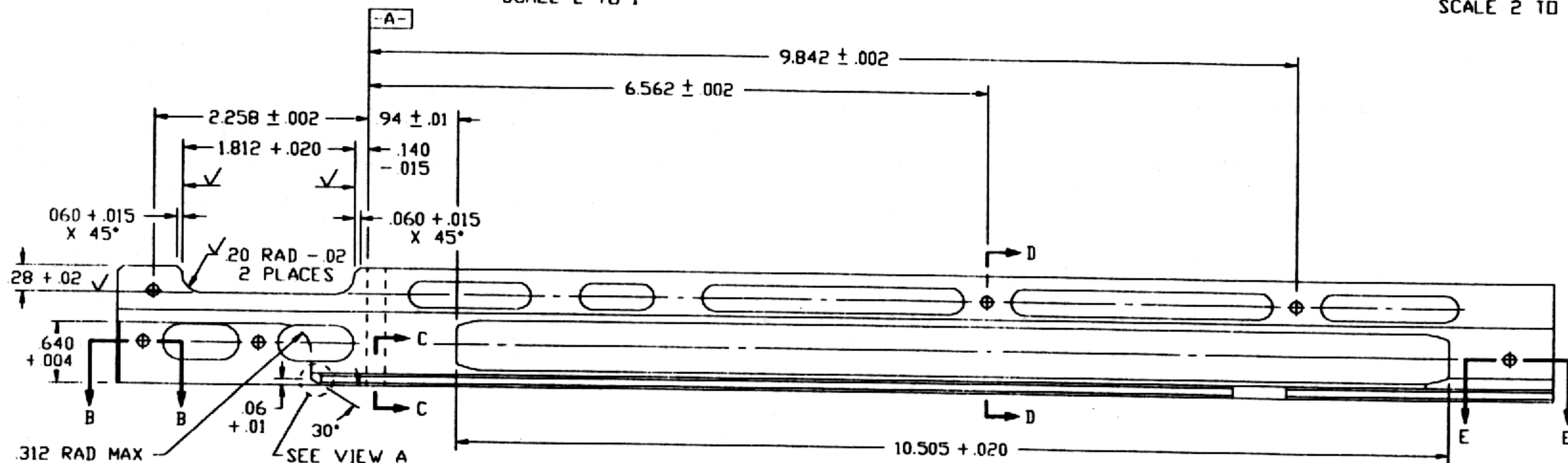
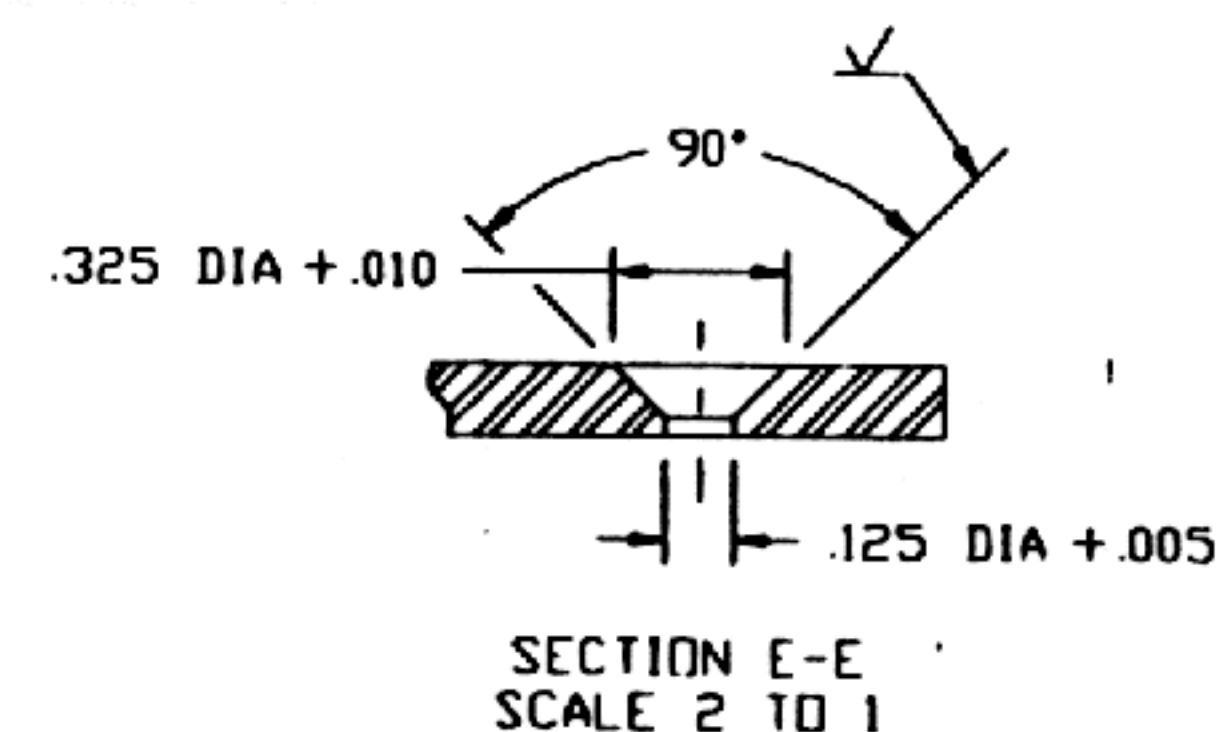
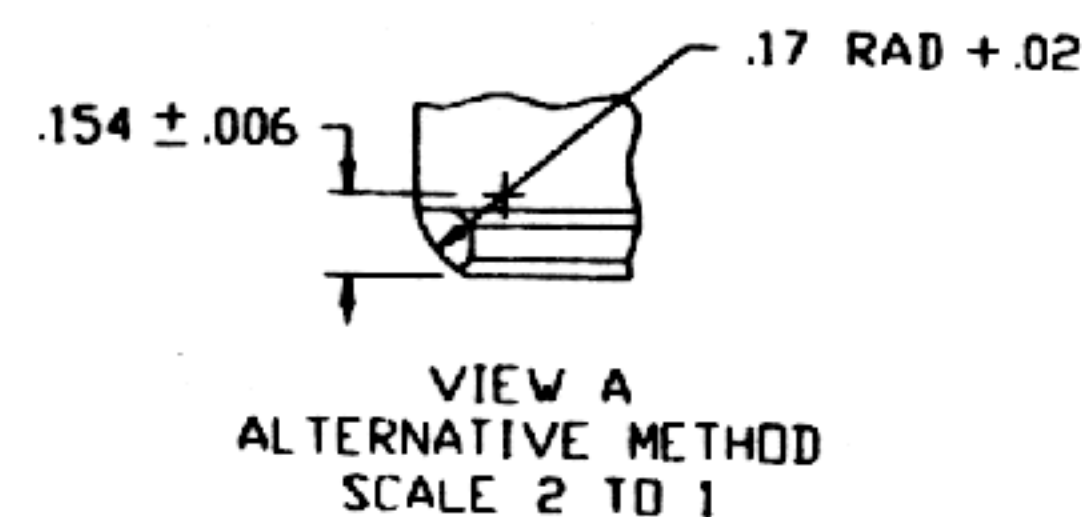
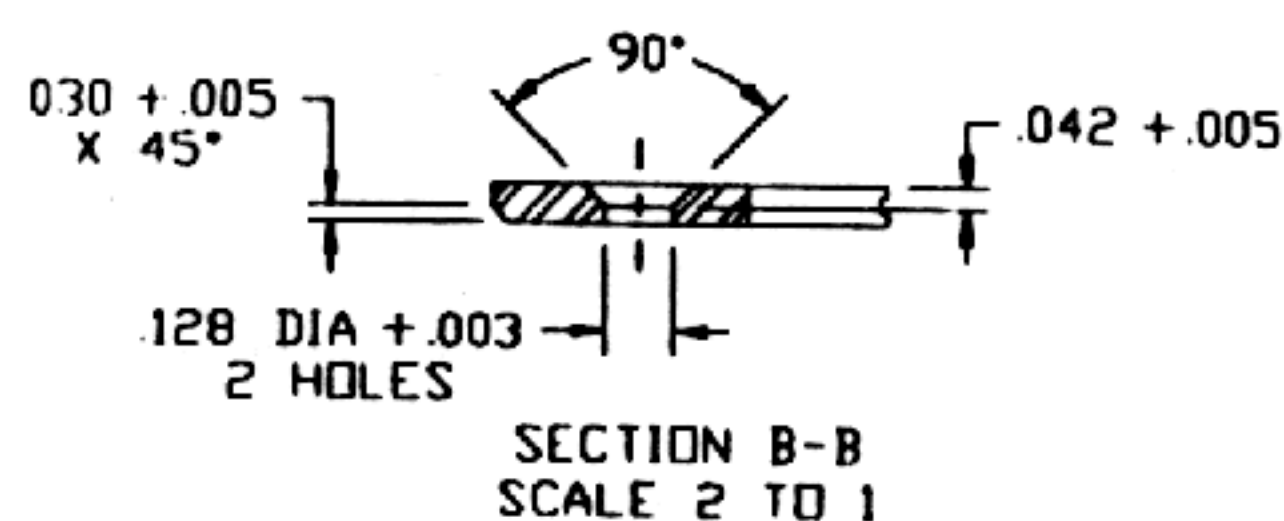
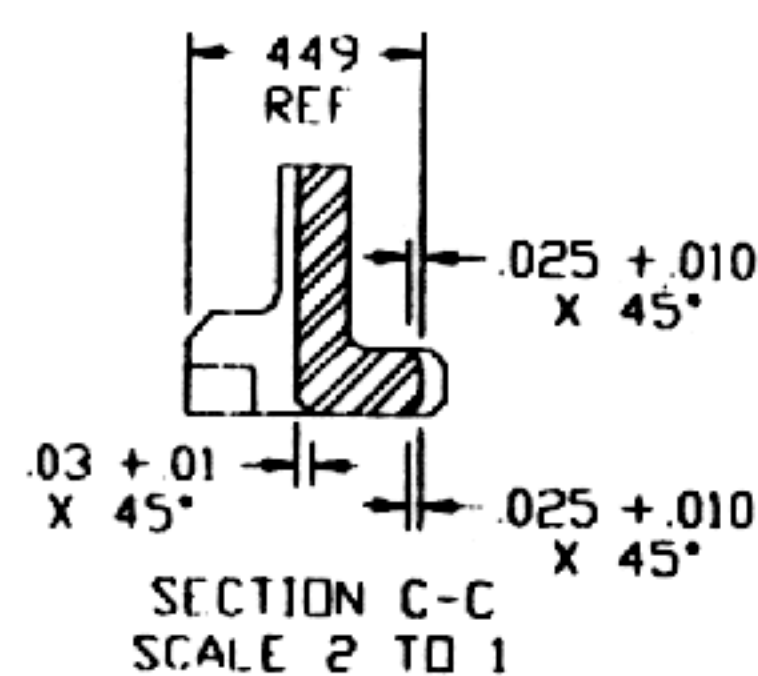
NEXT ASSEMBLY	F11686308	MG, 7.62 MM - M60, M60C.
	F11699805	M60D

CODE IDENT NO. 19205  
DRAWN FROM ORD PART NO. 7269259  
SPRINGFIELD ARMORY ORDNANCE CORPS  
DEPT OF THE ARMY  
SPRINGFIELD 1, MASS

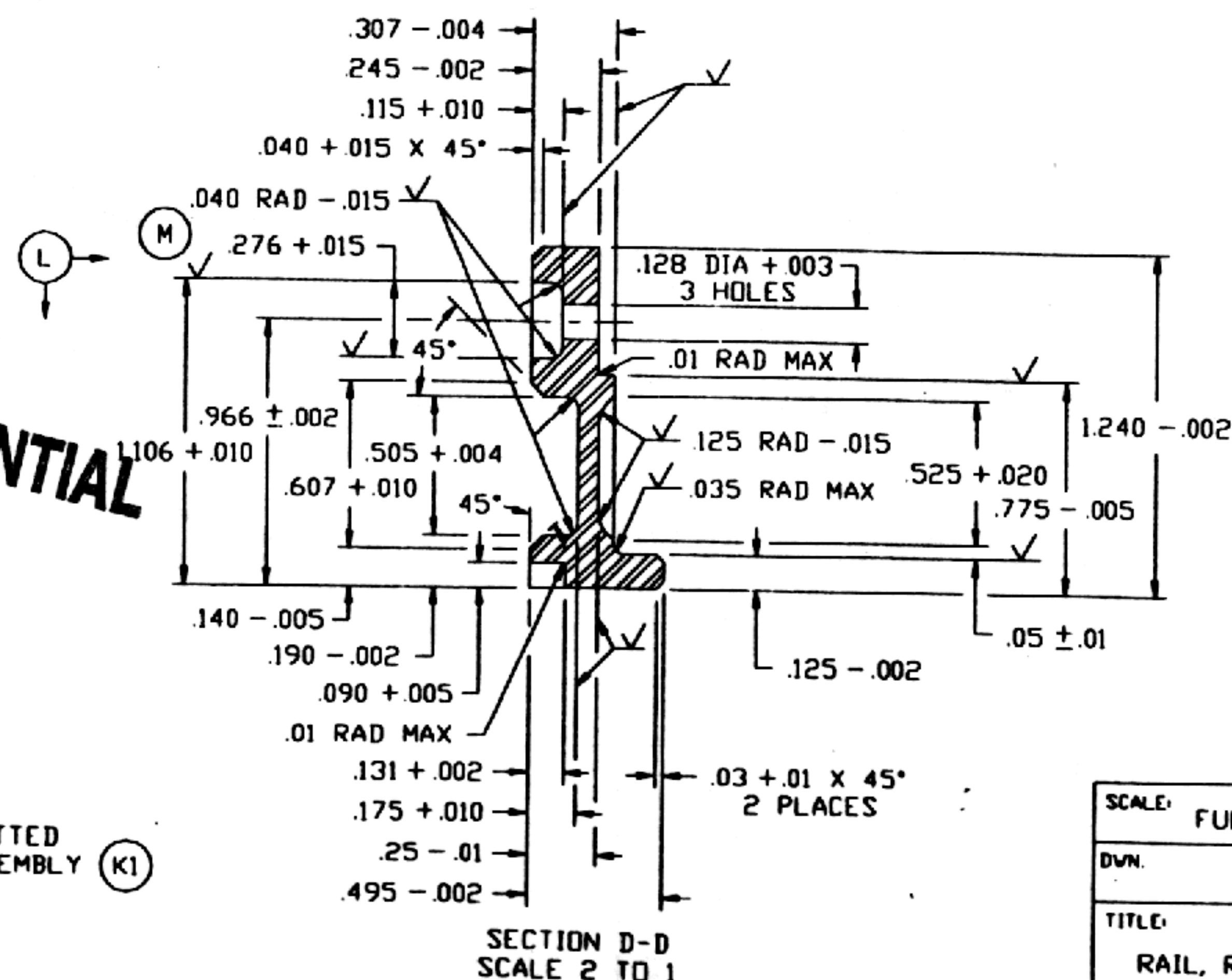
SYM	DESCRIPTION
K	REDRAWN WITH CHANGE SEE EO NO. SA30121
L	(1) SEE EO HRD 82232

SCALE	FULL	MATERIAL	SEE NOTE 6	CKD.	DATE	REV.	TOLERANCES
DWN.		FINISH	SEE NOTE 1				DEC 2 PL ± .02 H H ± .51 DEC 3 PL ± .005 H H ± .127 ANGLES ± .5°
TITLE	M60 RAIL, RECEIVER, LOWER						NO.





VIEW F-F  
(SEE SHEET 1)



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**RESTRICTED  
MATERIAL**

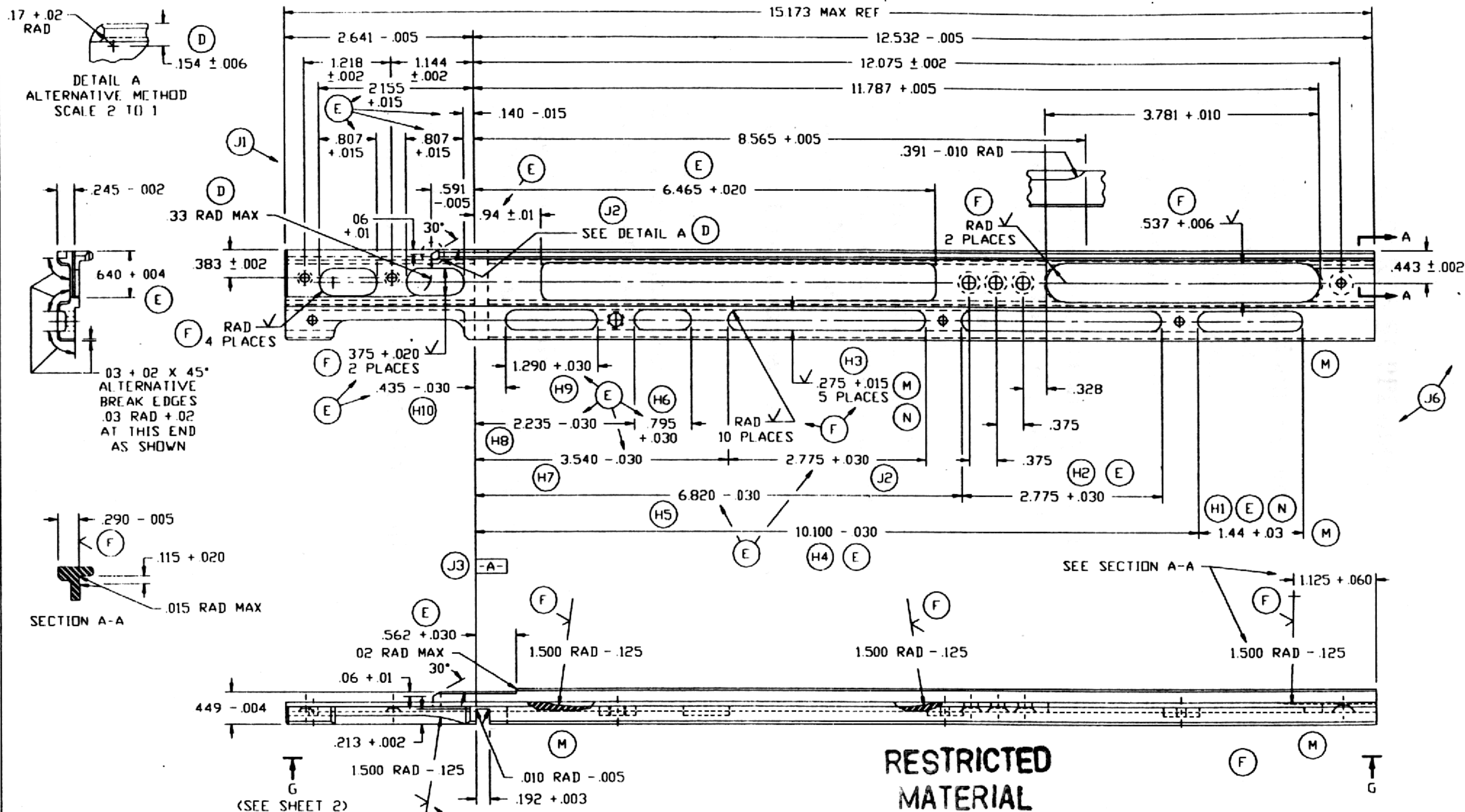
SYM	DESCRIPTION
J	REDRAWN WITH CHANGE SEE ED NO. 30122
K	(6) SEE ED HRD 82232
L	(1) SEE ERR HDR 10715
M	SEE ERR HDR 40604

CODE IDENT NO. 19204  
DRAWN FROM ORD PART NO. 7269258  
ROCK ISLAND ARSENAL  
DEPT OF THE ARMY  
ROCK ISLAND, ILL

NOTE:  
ALL RIVET HOLES AND THEIR COUNTERSINKS MAY BE OMITTED  
OR LEFT UNDERSIZE PROVIDED THEY ARE PUT IN AT ASSEMBLY  
TO THE DIMENSIONAL REQUIREMENTS APPLICABLE  
AT THE COMPONENT LEVEL. (K1)

SCALE: FULL	MATERIAL: SEE SHEET 1	CKD.	TOLERANCES
DWN.	FINISH: SEE SHEET 1	DATE	DEC 2 PL ±.02 M H ±.01
TITLE: M60 RAIL, RECEIVER, LEFT HAND	REV.	NO.	DEC 3 PL ±.005 M H ±.027 ANGLES ± 5°





RESTRICTED MATERIAL

- NOTES:
1. FINISH  $125\sqrt{\phantom{x}}$  EXCEPT SURFACES MARKED  $250\sqrt{\phantom{x}}$  FINISH  $250\sqrt{\phantom{x}}$  (F)
  2. ALL EDGES SHALL BE BROKEN .005 + .010 UNLESS OTHERWISE SPECIFIED.
  3. HEAT AT 1535° TO 1565° F. OIL QUENCH. TEMPER 1 HOUR TO HARDNESS SPECIFIED. HEAT TREAT METHOD IS FOR GUIDANCE EXCEPT THAT TEMPERING TIME SHALL NOT BE REDUCED BELOW THAT SPECIFIED.
  4. HEAT TREAT BEFORE MACHINING.
  5. FINAL PROTECTIVE FINISH: FINISH 5.3.1.2 OF MIL-STD-171 (N)
  6. ALL RIVET HOLES AND THEIR C'SINKS MAY BE OMITTED OR LEFT UNDERSIZE PROVIDED THEY ARE PUT IN AT ASSEMBLY TO THE DIMENSIONAL REQUIREMENTS APPLICABLE AT THE COMPONENT LEVEL.
  7. MIL-W-13855 APPLIES. (L1) (M)
  8. MATERIAL - STEEL QQ-S-624 4140, 8640, 8740

SYM	DESCRIPTION				
B		NEXT ASSEMBLY	F11686308	MG, 7.62 MM - M60, M60C.	
C	REDRAWN & REVISED SEE ED SA24642		F11699805	M60D	
D	REF ED NO. SA24924	CODE IDENT NO. 19204 DRAWN FROM ORD PART NO. 7269260 (G1) (K) ROCK ISLAND ARSENAL DEPT OF THE ARMY ROCK ISLAND, ILL			
E	REF ED NO. SA26992				
F	REF ED NO. SA27297				
G	(1-2) SEE ED SA28042				
H	SEE ED NO SA28992	SCALE: FULL	MATERIAL: SEE NOTE 8	CKD.	TOLERANCES
J	(1-6) ED NO. SA	DWN.	FINISH: SEE NOTE 1	DATE	DEC 2 PL ± .02 H H ± .51
K	SEE ED NO. SA14466	TITLE: M60 RAIL, RECEIVER, RIGHT HAND		REV.	DEC 3 PL ± .005 H H ± .127
L	(1-2) SEE ED HRD 82232				ANGLES ± 5°
M	(1-6) SEE ERR HDR 10715				
N	(3) SEE ERR HDR 60604				



## **LIST OF PARTS SUPPLIERS**

**wholesale guns and ammo, inc.**  
**232 blydenburgh rd.**  
**central islip, NY 11722**

**[www.gunsnammo.com](http://www.gunsnammo.com)**

**international military antiques , inc.**  
**p.o.box 256 millington ,NJ 07946**

**[www.ima-usa.com](http://www.ima-usa.com)**

**inter ordnance of america l.p.**  
**3305 westwood industrial drive**  
**monroe , NC 28110**

**[www.inter-ordnance.com](http://www.inter-ordnance.com)**

**sarco , inc.**  
**323 union st. p.o. box 98**  
**stirling , NJ 07980**

**jeffs shooters supply**  
**p.o.box 1054 trussville , AL 35173**

**rpb industries**  
**p.o.box 367 avondale est. GA 30002**